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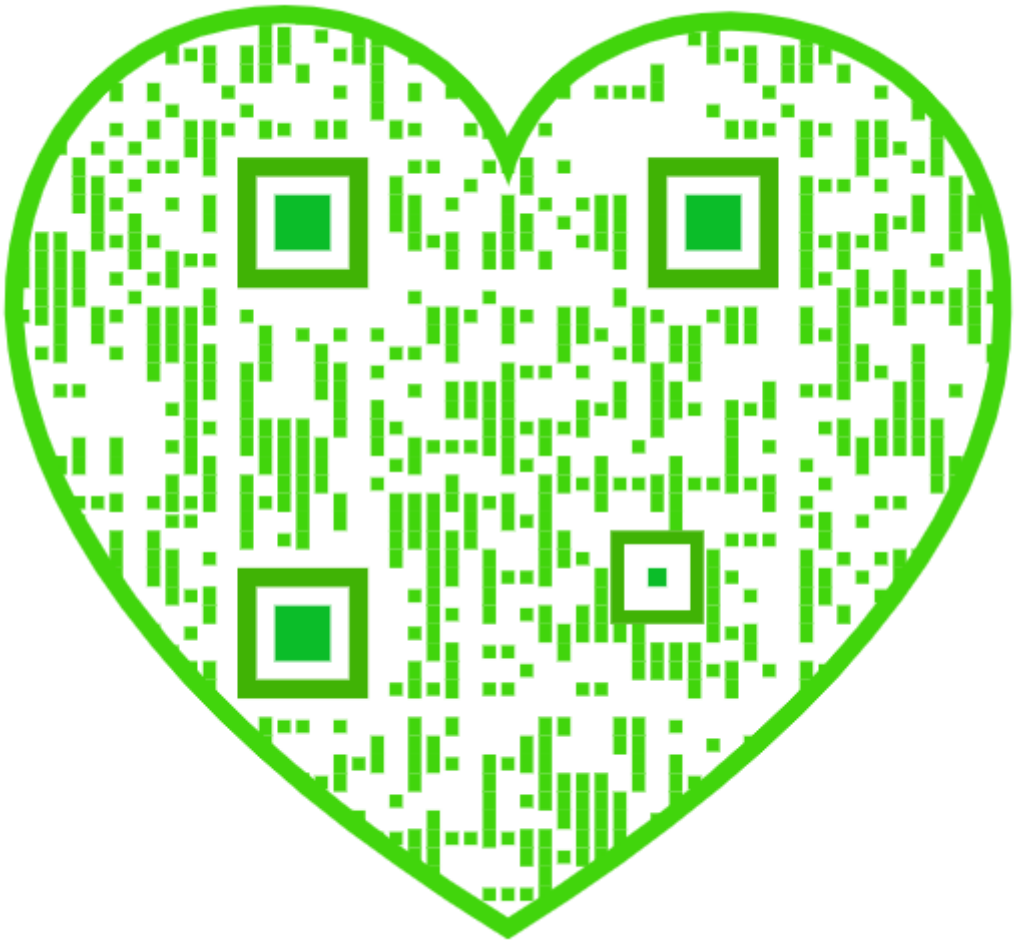

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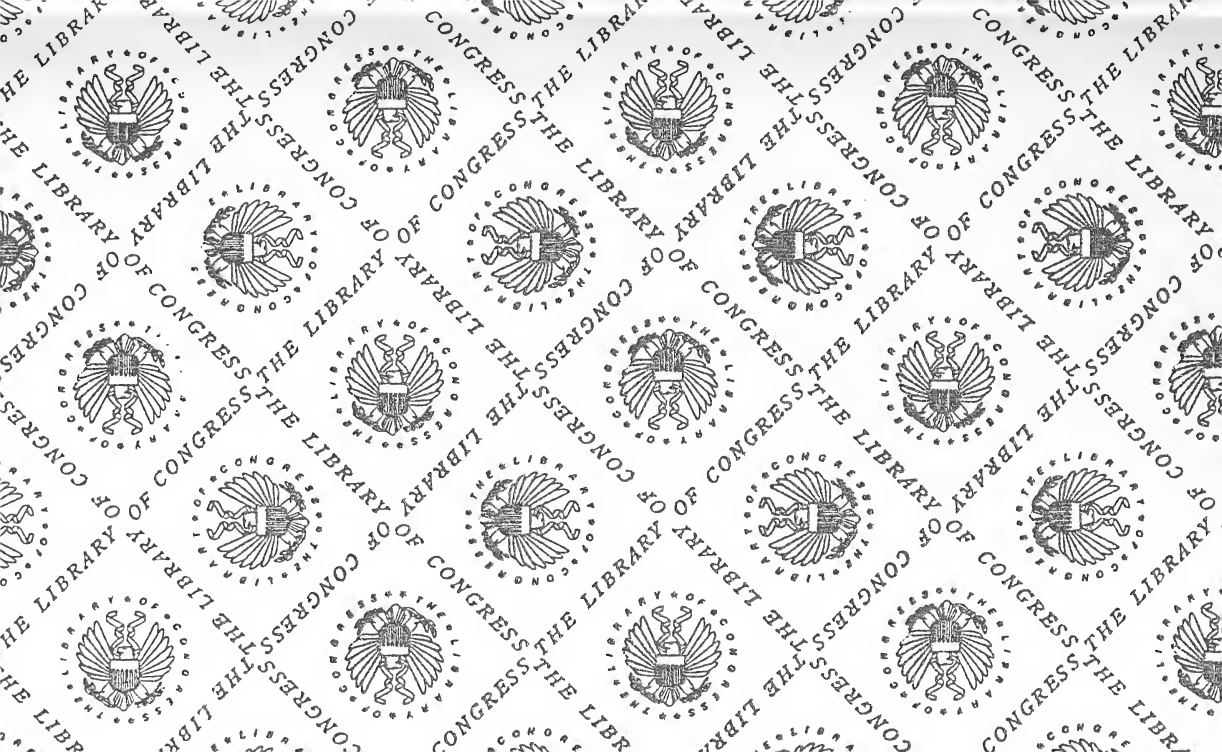
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Electro-Plating and Analysis of Solutions

A manual of information and instruction written for the benefit of the electro-plater and those interested in the art of electro-plating who wish to know something of the chemistry of electrolytic processes

By Herman H. Reama
Brooklyn, N. Y.

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Brooklyn, N. Y.

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PREFACE.

In compiling this book I have endeavored to make it practical in every detail, wording it in concise and simple language, and avoiding technical terms as much as possible.

I trust it will prove of benefit to my patrons, and in fact platers in general.

HERMAN H. REAMA.

Brooklyn, N. Y. 1913.

INTRODUCTION

I now wish to introduce a few of my ideas in regard to electro-plating, and incidentally a few ideas dealing with those points in chemistry which are of most benefit in the plating room.

My idea is to write a book entirely on plating and the analysis of plating solutions in general, which I know will be of great benefit to a plater.

I shall be as brief as possible in all my work, as simple methods are more easily grasped by the ordinary plater than difficult formulas that can only be understood by a graduate chemist.

I trust the readers will appreciate that the information contained in this book is only introduced with the idea of helping those who follow this line of business to acquire more skill in the plating line.

The sources of current used for electroplating are the dynamo and the battery. Until the introduction of plating dynamos about sixty years ago, electro-plating was done exclusively by batteries of various kinds, but at the present time the dynamo has almost entirely superseded them, except for amateur work and where power is not available.

H. H. Reama.

ELECTRICAL TERMS.

Volt: A volt is the unit of electrical pressure or electro-motive force, and is used the same as pound pressure when applied to a steam boiler or water pipe.

Ampere: An ampere is the unit of quantity, and is used to denote the amount of current flowing, in the same way that gallons or cubic feet per minute are used when applied to steam or water.

Ohm or **Resistance:** An ohm is the unit of resistance and corresponds to the friction that exists where water is flowing through a pipe.

Therefore it can be readily seen that there exists a definite relation between the above electrical terms, namely: volt, ampere, and ohm, and a volt represents the pressure exerted by a current of electricity of one ampere flowing through a resistance of one ohm. The electrical formula is expressed as follows:

$C = \frac{E}{R}$ in which of course "C" is the amount of current or amperes, — "E" is electro-motive force or volts, while "R" is resistance or ohms. Consequently we have E (volts) = C (amperes) $\times$ R (ohms) and R (ohms) = $\frac{\text{E (volts)}}{\text{C (amperes)}}$

CONDUCTORS.

It has been stated by competent and qualified people that by using bus-bars of the type shown in Fig. 1, say ½ x 1¼ or ⅝ x 1½ inches will give better service than the ordinary round bar. This is strictly a

Fig. 1—Rectangular Buss Bar

matter of opinion and is still up to the man in charge or in ownership of the said factory or shop. As heretofore stated many means of

Fig. 2—Round Buss Bar

operating can be and are used at the present writing, and it is quite difficult to meet all requirements and all classes of trade and still meet the approval of the majority. Nevertheless, facts are facts, and the above are true.

CLEANING CAST IRON BEFORE PLATING.

Steep the work in a solution of potassium hydrate (caustic potash), then rinse in clean water, dip in sulphuric pickle, (1 gallon of sulphuric acid to 10 gallons water), until free from all scale, scour with pulverized pumice and tampico brush or wheel. Then rinse in clean water and dip in a dilute muriatic acid pickle, rinse in clean water, and if work is porous rinse in lime water (if not porous it is not necessary) then rinse in clean water and hang in plating solution.

Some people use oxalic acid in place of muriatic acid (one pound of oxalic acid to 1 gallon water is a very good solution.)

A 1 CLEANING COMPOUND OR CLEANING SOLUTION.

100 pounds alkali (potash) (potassium hydrate),
75 " sal soda, (carbonate of sodium),
20 " light fish oil,
Heat at first, then add alkali and sal soda.
1 gallon 26° ammonia, (aqua ammonia, ammonium hydrate),
¼ pound borax soap cut up in pieces.
2 pounds cream of tartar.

CLEANING OF METALS BEFORE PLATING.

That should not be scoured.

The success of all kinds of electro-plating depends greatly upon the work being chemically clean; that is, free from all grease and dirt. This especially applies to nickel-plating, as the chemical character of a nickel solution is such that it has no dissolving action on grease, etc., and the deposit will surely strip or peel from the greasy spots. The operation of cleaning the articles differ in many establishments, but the following methods are those which have been found best from practical experience for copper, brass, britannia metal, tin, pewter, lead, and antimony and most any mixture of soft metals. Soft metals are such as are made from tin, lead, antimony, bismuth. Steep the work in a boiling solution of potash or lye, say 6 to 10 ounces of lye to 1 gallon of water.

The solution should stand about 10° Baumè, and be kept hot. After the work has been hanging in solution some time, rinse well in clean water. Then dip the work in a solution of cyanide of potassium made up say of ½ pound of cyanide to 1 gallon of water. This will remove any oxidization which may have formed on the work. Then rinse well in clean water, so that all potash and cyanide is thoroughly removed from the work, as none must on any account get into the solution.

Notice if the water wets the whole surface of the work, and runs off without running from some parts of the work only, as it does with anything that is greasy. If the work shows any signs of grease by the water not running off properly, then dip in potash and cyanide and rinse as before. Then hang work in solution at once without touching the work with the fingers, as grease from the fingers will adhere to the work and cause trouble.

Britannia metal and pewter should not be left long in the potash, as the solution exerts a solvent action on tin and its alloys.

ELEMENTS.

Following is given a list of all known elements with their atomic weights as reported by the International Committee an Atomic weights.

Element	Symbol	Atomic Weight
Aluminum	Al	27.1
Antimony	Sb	120.2
Argon	A	39.9
Arsenic	As	75.00
Barium	Ba	137.4
Bismuth	Bi	208.00
Boron	B	11.00
Bromine	Br	79.96
Cadmium	Cd	112.4
Caesium	Cs	132.9
Calcium	Ca	40.1
Carbon	C	12.00
Cerium	Ce	140.25

ELEMENTS.

Element	Symbol	Atomic Weight
Chlorine	Cl	35.45
Chromium	Cr	52.1
Cobalt	Co	59.00
Columbium	Cb	94.00
Copper	Cu	63.6
Erbium	E	166.00
Europium	Eu	152.00
Fluorine	F	19.00
Gadolinium	Gd	156.00
Gallium	Ga	70.00
Germanium	Ge	72.5
Glucinum	Gl	9.1
Gold	Au	197.2
Helium	He	4.00
Hydrogen	H	1.008
Indium	In	115.00
Iodine	I	126.97
Iridium	Ir	193.00
Iron	Fe	55.9
Krypton	Kr	81.8
Lanthanum	La	138.9
Lead	Pb	206.9
Lithium	Li	7.03
Magnesium	Mg	24.36
Manganese	Mn	55.00
Mercury	Hg	200.00
Molybdenum	Mo	96.00
Neodymium	Nd	143.6
Neon	Ne	20.00
Nickel	Ni	58.7
Nitrogen	N	14.01
Osmium	Os	191.00
Oxygen	O	16.00

ELEMENTS.

Element	Symbol	Atomic Weight
Palladium	Pd	106.5
Phosphorus	P	31.00
Platinum	Pt	194.8
Potassium	K	39.15
Praseodymium	Pr	140.5
Radium	Ra	225.00
Rhodium	Rh	103.00
Rubidium	Rb	85.5
Ruthenium	Ru	101.7
Samarium	Sm	150.3
Scandium	Sc	44.1
Selenium	Se	79.2
Silicon	Si	28.4
Silver	Ag	107.93
Sodium	Na	23.05
Strontium	Sr	87.6
Sulphur	S	32.06
Tantalum	Ta	181.00
Tellurium	Te	127.6
Terbium	Tb	159.2
Thallium	Tl	204.1
Thorium	Th	232.5
Thulium	Tu	171.00
Tin	Sn	119.00
Titanium	Ti	48.1
Tungsten	W	184.00
Uranium	U	238.5
Vanadium	V	51.2
Xenon	X	128.00
Ytterbium	Yb	173.00
Yttrium	Y	89.00
Zinc	Zn	65.4
Zirconium	Zr	90.6

EQUATIONS.

The following are some simple equations which are frequently encountered in plating operations.

$Hg + O = Hg\,O$ $\qquad$ $Mg + O = Mg\,O$

$HCl + NH_3 = NH_4\,Cl$

$H_2O + CaO = CaO_2\,H_2$

$H_2SO_4 + 2KNO_3 = K_2SO_4 + 2HNO_3$

$2HNO_3 + Na_2CO_3 = 2NaNO_3 + CO_2 + H_2O$

$2HCl + Zn = ZnCl_2 + 2H$

$CH_4 + 2Cl = CH_3Cl + HCl$

$Zn + H_2SO_4 = ZnSO_4 + 2H$

$BaO_2 = BaO + O$ $\qquad$ $3MnO_2 = Mn_3O_4 + 2O$

$8KClO_3 = 5KClO_4 + 3KCl + 4O$

With sulphur $S + 2O = SO_2$

With carbon $C + 2O = CO_2$

With iron $3Fe + 4O = Fe_3O_4$

With phosphorus $2P + 5O = P_2O_5$

$K + H_2O = KOH + H$

$Na + H_2O = NaOH + H$

$3Fe + 4H_2O = Fe_3O_4 + 8H$

$C + H_2O = CO + 2H$

$Zn + 2HCl = ZnCl_2 + 2H$

$Zn + H_2SO_4 = ZnSO_4 + 2H$

$Fe + 2HCl = FeCl_2 + 2H$

$Fe + H_2SO_4 = FeSO_4 + 2H$

$CuO + 2H = H_2O + Cu$

$Fe_2O_3 + 6H = 2Fe + 3H_2O$

$Fe_3O_4 + 8H = 3Fe + 4H_2O$

$3Fe + 4H_2O = Fe_3O_4 + 8H$

$Ca + 2H_2O = CaH_2O_2 + 2H$

$Ba + 2H_2O = BaH_2O_2 + 2H$

$KClO_3 = KCl + 3O$

$H_2O = 2H + O$ $\qquad$ $CaCO_3 = CaO + CO_2$

WEIGHTS AND MEASURES.

Linear Measurements.

10 millimeters (mm.) = 1 centimeter (cm.)
10 centimeters = 1 decimeter (dm.)
10 decimeters = 1 meter (m.)
Equivalent, 1 inch = 2.5 cm. (approximately)

Square Measurements.

100 sq. millimeters (mm^2) = 1 sq. centimeter (cm^2)
100 sq. centimeters = 1 sq. decimeter (dm^2)
100 sq. decimeters = 1 sq. meter (m^2)

Cubic Measurements.

1000 cu. millimeters (mm^3) = 1 cu. centimeter (cc or cm^3)
1000 cu. centimeters = 1 cu. decimeter (dm^3)
1000 cu. decimeters = 1 cu. meter (m^3)
Equivalents, 1000 cc. = 1 liter (1 l.)
1 l. = 1 quart (approximately)

Conversion Table.

1 cc. of water (S.T.P.) = 1 g.
1 l. of water (S.T.P.) = 1 k.
30 g. = 1 ounce (approximately)
1 k. = 2.2 pounds (approximately)
1 g. = 15 gr. (approximately)
1 l. hydrogen = .09 g. (approximately)

Troy Weight.

24 grains	= 1 dwt.
20 dwts.	= 1 ounce.
12 ounces	= 1 pound.

Used for weighing gold, silver and jewels.

Apothecaries' Weight.

20 grains	= 1 scruple.
3 scruples	= 1 dram.
8 drams	= 1 ounce.
12 ounces	= 1 pound.

The ounce and pound in this are the same as in Troy weight.

Avoirdupois Weight.

27 11-32 grains	= 1 dram.
16 drams	= 1 ounce.
16 ounces	= 1 pound.
25 pounds	= 1 quarter.
4 quarters	= 1 cwt.
2,000 pounds	= 1 short ton.
2,240 pounds	= 1 long ton.

Dry Measure.

2 pints	= 1 quart.
8 quarts	= 1 peck.
4 pecks	= 1 bushel.
36 bushels	= 1 chaldron.

Liquid Measure.

4 gills	= 1 pint.
2 pints	= 1 quart.
31½ gallons	= 1 barrel.
2 barrels	= 1 hogshead.

Time Measure.

60	seconds	= 1 minute.
60	minutes	= 1 hour.
24	hours	= 1 day.
7	days	= 1 week.

28, 29, 30, or 31 days = 1 calendar month (30 ds.)
365 days = 1 year.

Circular Measure.

60	seconds	= 1 minute.
60	minutes	= 1 degree.
30	degrees	= 1 sign.
90	degrees	= 1 quadrant.
4	quadrants	= 12 signs.
360	degrees	= 1 circle.

Long Measure.

12	inches	= 1 foot.
3	feet	= 1 yard.
5½	yards	= 1 rod.
40	rods	= 1 furlong.
8	furlongs	= 1 statute mile.
3	miles	= 1 league.

Miscellaneous.

3	inches	= 1 palm.
4	inches	= 1 hand.
6	inches	= 1 span.
18	inches	= 1 cubit.
21.8	inches	= 1 Bible cubit.
2½	feet	= 1 military pace.

Weight Table.

10	milligrams (mg.)	= 1 centigram (cg.)
10	centigrams	= 1 decigram (dg.)
10	decigrams	= 1 gram (g.)
1000	grams	= 1 kilogram (k.)

Cloth Measure.

2¼	inches	= 1 nail.
4	nails	= 1 quarter.
4	quarters	= 1 yard.

Square Measure.

144	sq. inches	= 1 sq. foot.
9	sq. feet	= 1 sq. yard.
30¼	sq. yards	= 1 sq. rod.
40	sq. rods	= 1 rood
4	roods	= 1 acre.
640	acres	= 1 sq. mile.

Surveyors' Measure.

7.92	inches	= 1 link.
25	links	= 1 rod.
4	rods	= 1 chain.

10 square chains or 160 square rods = 1 acre.
640 acres = 1 sq. mile.
36 sq. miles (6 miles sq.) = 1 township.

Cubic Measure.

1,728	cubic inches	= 1 cubic foot.
27	cubic feet	= 1 cubic yard.
128	c. ft.	= 1 cord (wood).
40	cubic feet	= 1 ton (shpg.)

2,150.42 cubic inches = 1 standard bushel.
268.8 cubic inches = 1 standard gallon.
1 cubic foot = about four-fifths of a bushel.

Mariners' Measure.

6	feet	= 1 fathom.
120	fathoms	= 1 cable length.
7½	cable lengths	= 1 mile.
5,280	feet	= 1 statute mile.
6,085	feet	= 1 nautical mile.

METRIC EQUIVALENTS.

Linear Measure.

1 centimeter	= 0.3937	inches.
1 decimeter	= 3.937	in.=0.328 ft.
1 meter	= 39.37	in.=1.0936 yds.
1 dekameter	= 1.9884	rods.
1 kilometer	= 0.62137	mile.
1 inch	= 2.54	centimeters.
1 foot	= 3.048	decimeters.
1 yard	= 0.9144	meter.
1 rod	= 0.5029	dekameter.
1 mile	= 1.6093	kilometers.

Square Measure.

1 sq. centimeter	= 0.1550	sq. inches.
1 sq. decimeter	= 0.1076	sq. feet.
1 sq. meter	= 1.196	sq. yards.
1 ar	= 3.954	sq. rd.
1 hektar	= 2.47	acres
1 sq. kilometer	= 0.386	sq. m.
1 sq. inch	= 6.452	sq. centimeters.
1 sq. foot	= 9.2903	sq. decimeters.
1 sq. yard	= 0.8361	sq. meter
1 sq. rod	= 0.8361	sq. ar
1 acre	= 0.4047	hektar.
1 sq. m.	= 2.59	sq. kilometers.

Weights.

1 gram	= 0.03527	ounce.
1 kilogram	= 2.2046	lbs.
1 metric ton	= 1.1023	English ton.
1 ounce	= 28.85	grams.
1 pound	= 0.4536	kilogram.
1 English ton	= 0.9072	metric ton.

Approximate Metric Equivalents.

1 decimeter	= 4	inches.
1 meter	= 1.1	yards.
1 kilometer	= ⅝	of mile.
1 hektar	= 2 ½	acres.
1 stere or cu. meter	= ¼	of a cord.
1 liter	= 1.06	qt. liquid.
1 liter	= 0.9	qt. dry.
1 hektoliter	= 2 ⅝	bush.
1 kilogram	= 2 ⅕	lbs.
1 metric ton	= 2,200	lbs.

Measure of Volume.

1 cu. centimeter	= 0.061	cu. in.
1 cu. decimeter	= 0.0353	cu. ft.
1 cu. meter	= 1.308	cu. yd.
1 stere	= 0.2759	cd.
1 liter	= 0.908	qt. dry
1 liter	= 1.0567	qt. liq.
1 dekaliter	= 2.6417	gal.
1 dekaliter	= .135	pks.
1 hektoliter	= 2.8375	bush.
1 cu. inch	= 16.39	cu. cent'rs.
1 cu. foot	= 28.317	cu. deci'rs.
1 cu. yard	= 0.7646	cu. M'r.
1 cord	= 3.624	steres.
1 quart dry	= 1.101	liters.
1 quart liquid	= 0.9463	liter.
1 gallon	= 0.3785	dekaliter.
1 peck	= 0.881	dekaliter.
1 bushel	= 0.3524	hektoliter.

Electrical Requirements Necessary in a Plating Room.

IN the first place it is better to buy a first class dynamo even though it be a little more expensive in the beginning, it will prove to be the cheapest in the end. The dynamo should be set up on a good solid foundation and as near to the tanks as convenient, and should be placed so that your plater will have easy access to all its working parts. A few minutes attention given to the dynamo each morning adds greatly to efficiency, and will keep commutator and brushes in good condition. Be sure the dynamo rests firmly on its foundation. Great care should be taken in adjusting the brushes not to have too much pressure on commutator. The brushes should not bear too hard on commutator, but just enough to insure perfect contact between brush-holder and rod. If commutator shows signs of roughness, smooth with fine sand-paper, and lubricate with vaseline. Never use emery paper. The conducting bars running from the dynamo past the various tanks in the plating room should be large enough to carry all current that the dynamo gives, and the various vats can be connected by means of wires or rods leading from the conducting bars. Great care should be taken to have the wires of a sufficient size so as not to lose too much cur-

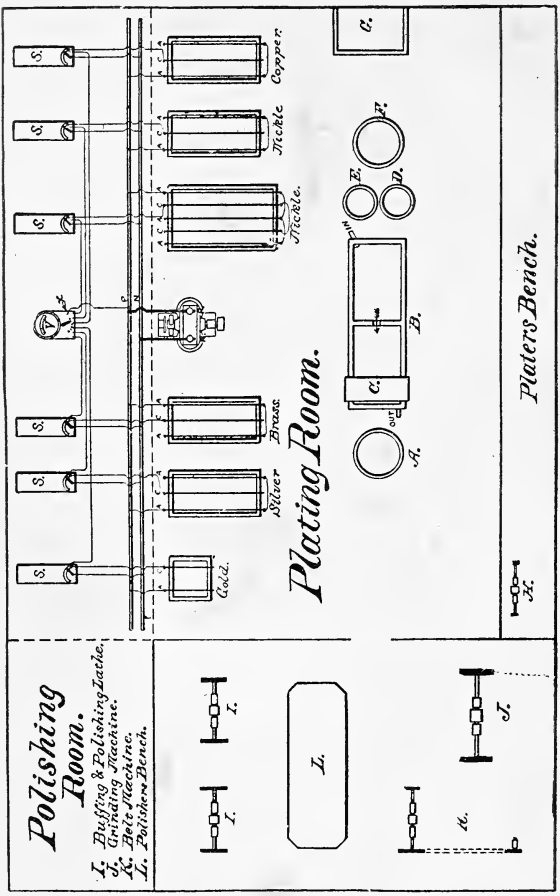


Fig. 3—Plan View of a Modern Plating and Polishing Room

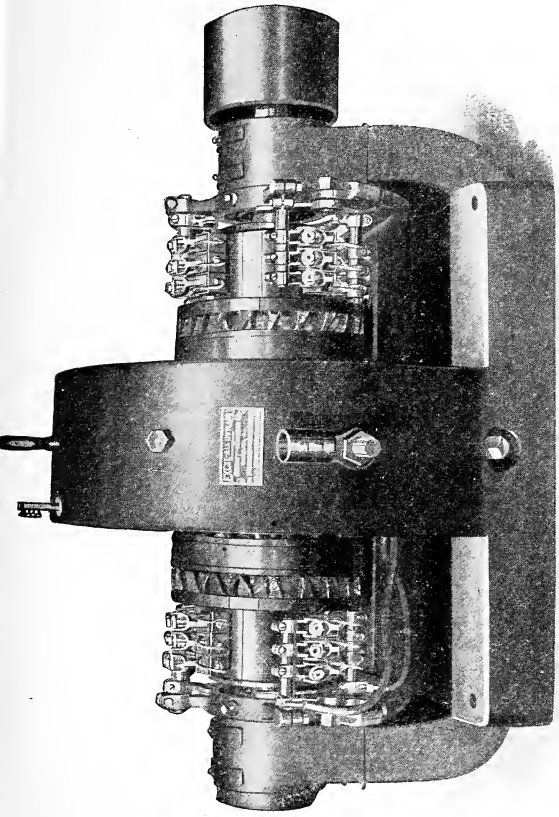


Fig. 4—"Excel-all" Plating Dynamo
Manufactured by Bennett-O'Connell Company, Chicago, Ill.

rent. The current must be regulated for each tank by a resistance switch or rheostat connected to the positive bar and also to the positive bar of the tank. Rheostats are put up as

near to the tank as possible, and should be shut off while putting work into tank, and then be turned toward the strongest point until a suitable current is obtained.

It is quite essential in a large plating room to have a voltmeter, and also an ampere meter,

Fig. 5—Ammeter for Electro-plating Work. Manufactured by Weston Electric Company, Newark, N. J.

which will show the plater the exact amount of current he is getting. By means of an accurate ammeter, the amount of metal actually deposited can be determined.

NICKEL PLATING.

The solution should be made up by dissolving ¾ of a pound of nickel-ammonium sulphate (double nickel salts) (1 gallon of water), which will bring the density up to about 6° or 7° Bé, and adding a small amount of boric acid, making a very fine bright nickel. In some instances, agitated solutions are of great importance, for the reason that a higher current density may be used, and decrease the time, prevent pitting, and the work will come out just as bright as in a still solution.

Anodes: Now as to anodes, they are very important in nickel solutions, owing to the fact that the solution does not readily dissolve the metal, as this action takes place only by the aid of the current, and as nickel sulphate will not conduct electricity properly, and as ammonium sulphate will, we have combined them and make the double salt, and the free sulphuric acid liberated by the deposition immediately passes to the opposite pole, and attacks the anodes. A large anode surface is necessary. Cast anodes are preferable, as rolled anodes are so hard that more current is required.

Bath: The bath should be slightly acid. This condition can be readily told, by testing with litmus paper. Blue litmus paper is colored red by acid, and red litmus paper is colored blue by an alkali. Too much acid will

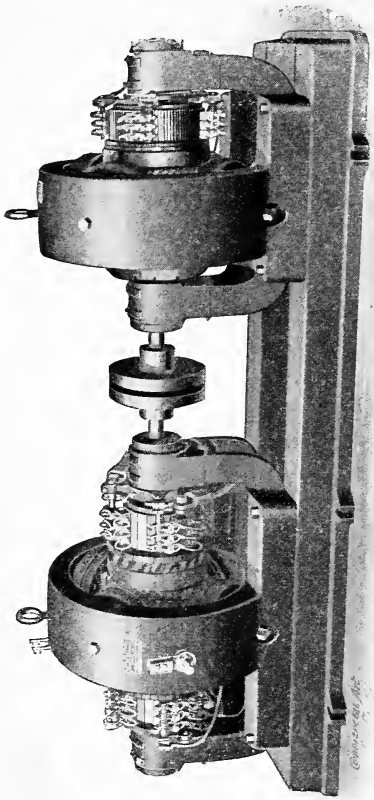


Fig. 6. "Excel-all" Motor-Generator
Manufactured by Bennett-O'Connell Company, Chicago, Ill.

cause peeling, and if the bath is alkaline a dark deposit will be obtained. The solution should be kept always at 6½ to 7° Bé.

COPPER PLATING.

A very fine bright deposit of copper can be obtained by making a solution of

1 gallon of warm water,
5 ounces of carbonate of copper,
10 " " cyanide of potassium,
2 " " bisulphite of soda.

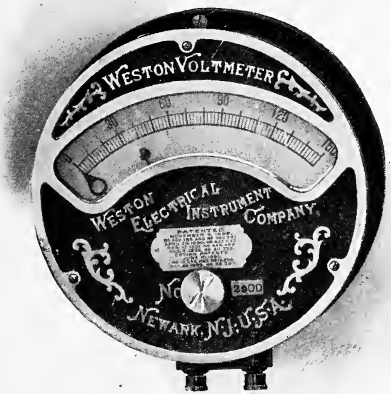


Fig. 7—Voltmeter used in Electro-plating
Manufactured by Weston Electric Company, Newark, N. J.

Sometimes a person may have trouble owing to his copper solution not depositing any copper. As a rule this is due to insufficient cyanide. As for example, if there is not enough cyanide in the bath, the anodes will become coated with a greenish coat. Remedy.

add cyanide. When the bath is working properly, there will be no traces of green upon the anodes, and the work hung in the tanks to be plated should be rapidly covered with metal. On the other hand when there is too much cyanide in the bath, hydrogen bubbles will come very freely from the work to be plated. Remedy, add copper cyanide.

The above solution is for ordinary work. Of course there are various ways of running a copper solution. For instance, if a copper solution is to be used for striking steel knives before silver plating them, this solution should be made rich with cyanide, and just enough carbonate of copper to deposit freely.

To make this solution use about
8 ounces of Cyanide of potassium.
4 " " Carbonate of copper.

When this solution is first tried if there is no deposit, add carbonate of copper slowly until a good deposit is obtained. If the work blisters by using a strong current, reduce the current. If it still blisters, add a little more cyanide. The solution should stand about 10° Bé.

BRASS PLATING SOLUTION.

The brass plating solution seems to be the most difficult of all solutions to handle, and there are several ways of running a brass solution for various kinds of work, and if a

man has had a little experience in brass plating he will readily understand what kind of a solution is needed for the work he is about to plate. In my experience I have used several different brass solutions, and have plated several kinds of metals in different lines of work, and I find that in plating lead work or any white metal, that a solution made up of about

1 Gallon of water,
7 Ounces of carbonate of copper,
4 " " " " zinc,
15 " " cyanide of potassium.

A small amount of arsenic dissolved in caustic soda, and a small quantity of ammonia, will bring very good results.

Now in making up this solution, fill the vat half full of water, then take dry carbonate of copper and carbonate of zinc, and weigh at the rate of 5 to 3 parts and put in a stone crock. Fill the crock with water and stir all together; then in another crock put cyanide and dissolve it, then take a pail and fill it half full of the copper and zinc solution and add the cyanide solution to it, and keep stirring until the solution becomes clear, and then add to the vat. When all the metal and cyanide are in the vat, fill up with water, then add a small amount of arsenic, and then about one gallon of ammonia to every 50 gallons. Care should be taken in using the arsenic, not to add too much. A very small amout is sufficient, and

when this solution is tried if it does not work nice and clear, simply add a little more ammonia.

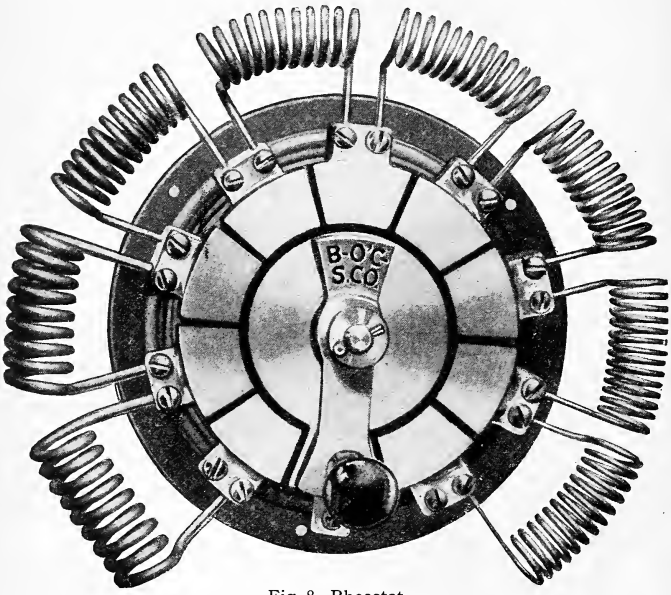


Fig. 8—Rheostat
Manufactured by Bennett-O'Connell Company, Chicago, Ill.

Now I find that on plating sheet metal work that I obtain far better results by using the following solution:

1 Gallon of water,
12 Ounces of carbonate of copper,
7 " " " " zinc,
25 " " cyanide of potassium,
A small amount of ammonia.

TUMBLING BARREL PLATING.

Tumbling barrels have almost entirely done away with wiring or basket plating for small work such as screws, collar buttons, etc., and at the present day they turn out this class of work in tumbling barrels in large quantities and in this way reduce the cost to a much smaller figure than when it was done by the old method.

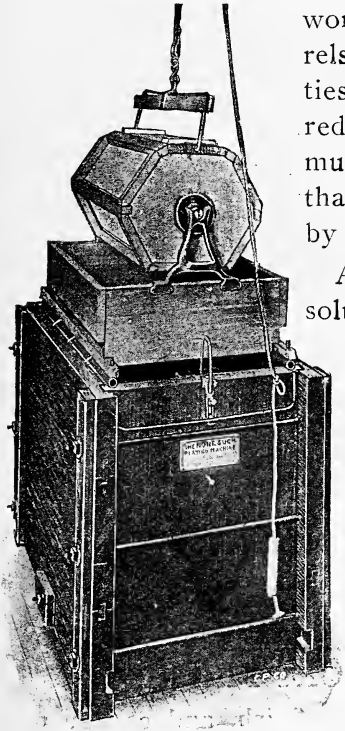


Fig. 9—"None Such" Electro-plating Barrel Manufactured by Rockhill & Vietor New York

A very good brass solution for tumbling barrel plating is made as follows:

Carbonate of copper .....12 oz.
Carbonate of zinc 6 oz.
Cyanide of potassium ....20 oz.
Water .... 1 gal.

Ammonia and arsenic may be added to brighten deposit.

ARGENT IVORY OR SILVER WHITE.

This is an exceptionally fine white finish, burnished on certain parts, and is produced in the silver solution by running the work just long enough to get a dead white, and rinsing in cold and hot water, and then in cold again, and dry in soap suds or alcohol, and then burnish using Ivory Soap for the burnishing. In this way one is not so liable to stain the work, or burnish dry, which in some cases is preferable as this finish stains very easily. This white finish should be lacquered with a pure White Celluloid Lacquer.

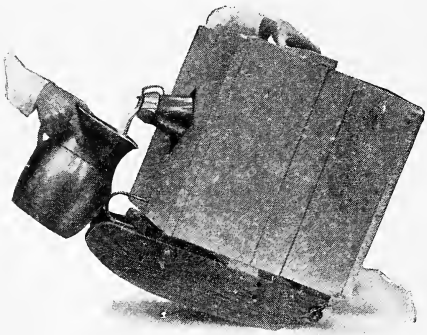


Fig. 10—"None Such" Carboy Rocker
"Beginning to Pour"
Manufactured by Rockhill & Vietor, New York

OLD IVORY FINISH.

This is a beautiful finish, and can be produced in several ways. One can get a very fine finish by using White Enamel Lacquer

and spraying it on the work, and when dry apply with a camels hair brush, burnt umber ground with oil and thinned with turpentine until the shade desired is obtained. A small amount of burnt umber to about 6 to 8 ounces of turpentine will give a fine tan color, which is a very fine color to apply on the white. Rub off with turpentine with a small piece of felt or chamois. A still better way to produce this Old Ivory is to produce the white in the silver solution, run the work just long enough to get a dead white, and then rinse off in cold and hot water, and then in cold water, and then dry in alcohol or soap suds and lacquer. Apply burnt umber as before.

For the cheap class of work the cost of this finish can be reduced by first running the work in an acid copper solution for about ½ hour which will give a dead finish. Then silver plate. In this way the dead white is produced in about half the time in silver solution, thus saving silver.

SILVER PLATING CASKET HARDWARE.

In presenting this subject, I desire to illustrate the handling of this line of work from the stringing or racking up to the buffing department.

The work is first wired or racked up, then it is dipped in the potash and rinsed off in clean water, nickel plated for about five minutes,

rinsed in clean water, put into the silver strike solution for a minute or two, then into the bright silver solution, where it is usually run for about five minutes. This class of work must come out of the silver solution bright and clear, and without stain, as some of the cheap work goes through without any buffing, and the work that is to be buffed has to be done simply by color buffing. When the work comes out of the silver solution it should be rinsed in cold water, and then in hot water, and then hung in an oven at 150 to 200° F. until thoroughly dry. It is then ready for buffing.

The potash for this class of work should stand about 5 Bé, and not any higher, as the work must not stain when potashing. The nickel solution should be made of ¾ pound of double nickel salts to a gallon of water, and should stand about 6 to 7 Bé. A small amount of table salt added to this solution occasionally will whiten the deposit. The silver strike solution should be made up of about 10 ounces of cyanide of potassium to the gallon, and ½ ounce of silver chloride to a gallon of water. The silver solution should contain 2 ounces of silver chloride and about 12 ounces of cyanide of potassium per gallon of water, and add bisulphide of carbon in the usual manner to brighten the deposit. Care should be taken in adding this brightener, as too much will give very bad results.

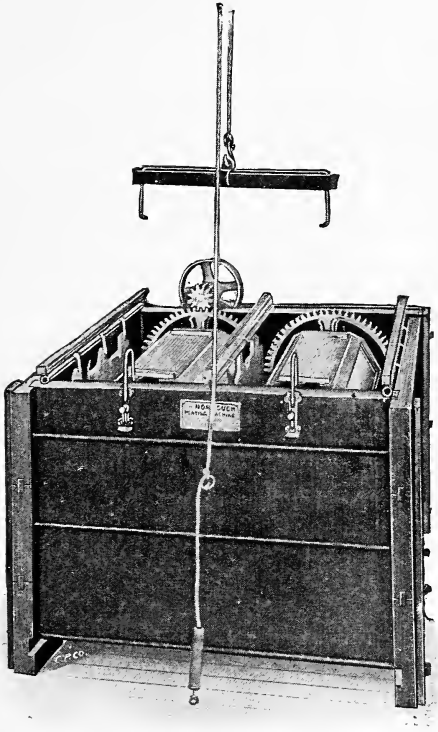


Fig. 11—"None Such" Plating Barrel Double Type
Manufactured by Rockhill & Vietor, New York

SILVER PLATING STEEL KNIVES.

The knives are first placed in a basket, and then washed in benzine and shaken through sawdust which will remove oil, and potash in the usual way. Potash should stand about 15 Bé. After taking out of potash, rinse in clean water and place in carbonate of soda solution to prevent rust, and scour with fine pumice, rinse in clean water and rack up. Then dip in dilute sulphuric acid dip in proportion of 1 part of acid to 8 parts of water, then rinse in clean water and hang into a steel strike. The steel strike is made up of

Carbonate of copper. 10 Grains.
Chloride of silver... 5 "
Cyanide of potassium 10 Ounces.
Water ..... 1 Gallon.

Use copper anode 2 x 8 inches in cloth bag.
Silver " 1 inch square.

It is advisable at the end of each week to take out about 1 gallon of the strike solution and add about 1 quart of silver solution and cyanide enough to keep the solution standing 10 Bé. Never add any copper to the strike after first making, as all the copper required is obtained from the anode. After striking the knives in steel strike, they should be rinsed in clean water, and struck up in the regular silver strike, and from there into silver solution. The silver solution should always stand about 15° to 18° Bé, and have 4 to 4½ ounces of chloride of silver per gallon, and 15 to 20

ounces of cyanide of potassium per gallon. It is best to keep the knives in motion while plating by means of a swing frame attached to the negative pole, which is the plating pole. A scale attachment which will register the amount of silver being deposited can also be obtained.

SILVER PLATING HOLLOW WARE.

Brass, Copper, or German Silver.

The work is first dipped in potash standing about 15 Bé, rinsed in clean water, scoured with fine pumice on a tampico brush or wheel, allowing a steady drip of water to flow on the wheel while work is being scoured, so as to keep work wet, then sponge off thoroughly in clean water and hook or wire up, when it is ready for plating. The work is then hung in a clean water vat until the plater is ready to handle it. On removal, dip in potash standing about 10 Bé, rinse in clean water and dip in mercury dip, rinse in clean water, and dip in potash, and then in a weak cyanide of potassium dip, and from this into silver strike solution, where it is struck up for a few minutes, and then into silver solution where it remains until the desired amount of silver is deposited. This method is for burnish or satin finished work.

Now if the work is only to be buff finished, a different method should be used in cleaning, as this class of work should come out of solu-

tion bright and without stain, as we only burnish parts that cannot be readily reached by the buff. Therefore, we use a solution of Kalye about 8 ounces to a gallon of hot water. Place work in Kalye solution a couple of minutes, wash off with a cotton flannel brush, scour only such parts as inside of tea pots, or under handle, etc., and then plate in a bright silver solution. For satin finish or burnished work it is best to use a solution composed of

Chloride of silver... 3 to 4 Ounces.
Cyanide of potassium15 to 18 "
Water ..... 1 Gallon.

Bright silver solution should contain

Chloride of silver... 2 to 2½ Ounces.
Cyanide of potassium12 to 15 "
Water ..... 1 Gallon.

Bisulphide of carbon should be added in the usual manner.

Silver Plating Lead or Spelter Articles.

In my experience, I have found that the best results in this line of work can be obtained by first washing the articles in benzine and then shaking through sawdust. They should then be hooked or racked up and dipped through potash, rinsed in clean water, strike in cyanide copper solution for a couple of minutes, and nickel plate about ½ hour. Then rinse in clean water, potash and rinse again and then place in silver strike solution, and plate in the ordinary silver solution until

the desired amount of silver is deposited. The reason for nickel plating is only to save silver, for instance, when you relieve an article for French Gray finish, you are liable to cut through on some little part, and if you have a nickel base under the silver, it in most cases would not be noticed.

ROSE GOLD.

I will now make a few remarks on the rose gold finish, which is a beautiful finish on almost any kind of work. There are several ways of producing this finish, for instance, if you want a fine rose finish on high class jewelry, you have to produce your smut by the use of an old gold solution, to which you may add a small amount of caustic potash, and use carbon anodes. I have found that adding carbonate of copper taken up with yellow prussiate of potassium in small quantities will give you a very fine red rose. Run work in this solution for a couple of minutes, then rinse in a weak cyanide of potassium dip, then relieve with bi-carbonate of soda, and then run into a roman gold solution, which consists of

2 Ounces of C. P. cyanide of potassium,
1 Gallon of water,
5 Pennyweights of fulminate of gold.

For cheap classes of work we can produce a rose finish which is very inexpensive, and which is also a very nice finish by producing the smut in an acid copper solution, and then

relieving with bi-carbonate of soda, and gold plating in a roman gold solution. I have also had pretty good success by using a dip gold solution made up of

1 Gallon of warm water,
5 Pennyweights fulminate of gold,
2 Ounces C. P. cyanide of potassium,
2 Ounces phosphate of soda,
1 Stick caustic potash.

GILDING INSIDE OF SPOONHOLDERS, CUPS, CREAM PITCHERS, ETC.

Gilding Solution:

Water ..... 1 Gallon.
Cyanide of potassium 8 Ounces.
Fulminate of gold...10 Pennyweights.

Fill cup with gold solution and hang anode in cup until you get desired color. Now in case you have a cream pitcher with a lip on it to gold line so that when you fill cup with solution it does not cover all parts that are to be gilded, the proper way to gild such a piece of work is to have a tight rubber band to place around the top so as to hold solution up to highest point in order to gild the lip. Or use wax which by some silver concerns is called "Gilders Wax." This wax should be heated in warm water until it becomes soft, so that it can be stretched out in any length or width desired, and place on work while warm. In this way you can gild any piece of work no matter what shape it may be. For instance,

if you have 25 cups with an uneven surface on top, you can heat a lump of this wax, enough to place over the lip of these 25 cups, and by the time you get wax on all of them, the first will be cool enough to proceed with the gilding. Then when all are gilded the wax should be taken off by placing in warm water, when it can be easily removed. Care should be taken not to have the water too warm.

Gilders Wax:

White Wax ..... 1 Pound.
Rosen ..... 2 Pounds.
Mix by heat.

GOLD PLATING 14 OR 18 KARAT COLOR ON JEWELRY.

In my experience I have found that there is but one way to make these solutions, and obtain first class results, and that is to purchase a 14 Karat anode, and run the gold into a cyanide solution by using a porous cup until you have drawn off about 10 pennyweights of your anode into 1 gallon of C. P. cyanide of potassium solution. Have the solution stand about 6° Bé. In this way you get a beautiful 14 to 18 Karat color, which will run very even. The richer the solution in gold, the richer color you will get. Therefore, when your solution is first made up with 10 pennyweights to the gallon, you will get about an

18 Karat color and as you use the solution it will go down to a 14 Karat, and you can get about any shade from a copper color to almost a 22 Karat in this way.

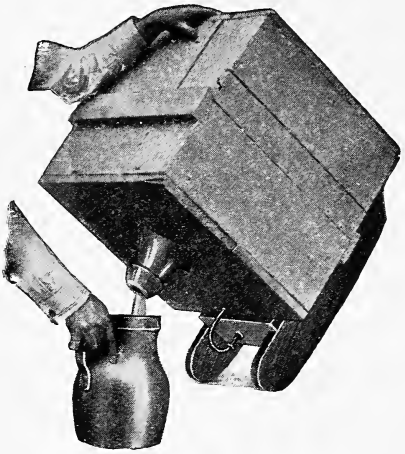


Fig. 12—"None Such" Carboy Rocker
"Getting Out the Last Drops"
Manufactured by Rockhill & Vietor, New York

DARK BROWN ON COPPER OR BRASS.

Water	1	Gallon.
Chlorate of potash	3	Ounces.
Sulphate of copper	3	"
Hyposulphite of soda	3	"
Acetate of copper	3	"

Use hot. In some cases Sulphate of nickel may be added.

BRIGHT FOR SILVER.

Chloroform or ether. 2 Ounces.
Bisulphide of carbon 4 "
Silver solution..... 2 Quarts.

GREEN GOLD.

A very fine green gold color can be produced in a solution of

10 Gallons of water,
10 Pennyweights of fulminate of gold,
20 Ounces C. P. cyanide of potassium,
3 Pennyweights chloride of silver,
2 Grains acetate of lead.

Ormulu Gold Finish on Lead Work.

The first thing to do is to see that your work is properly cleaned, and a very good way to clean this kind of work is to wash with benzine and dry out with sawdust; then wire or rack up your work, dip through potash and rinse in clean water, and hang into bright cyanide copper solution until coated all over with copper, then hang into your acid copper solution for from one to two hours according to the class of work you are doing; then dip into a bright dip composed of

1½ parts of oil of vitrol,
1 part of nitric acid.

Then rinse off thoroughly in clean water and hang in brass solution until you obtain a nice yellow brass. About 2 or 3 minutes is

sufficient. Then gold plate in salt water gold solution.

The brass solution for this class of work should be made up as follows:

1 Gallon of water,
12 Ounces of carbonate of copper,
6 " " " " zinc,
25 " " cyanide of potassium.
A small amount of ammonia.

The salt water gold solution should be made up of

8 Ounces yellow ferrocyanide (yellow prussiate of potassium),
24 Ounces carbonate of sodium,
16 " phosphate of sodium,
3 Pennyweights fulminate of gold,
1 Gallon of water.

In setting up this solution, you should get a red porous jar, and a copper kettle; place the jar in the kettle and place a piece of sheet zinc around the porous jar. The sheet zinc should be about ½ inch thick. A copper rod should be attached to the zinc with rivets so as to get a good connection. Stand the porous jar and zinc on either wood or glass in the bottom of the copper kettle. The salt water which is used to form battery should be made from rock salt (which is very cheap), and a little salammoniac, and should stand about 12° to 15° Bé, and should be heated with a copper coil.

Be sure and use copper or brass coil

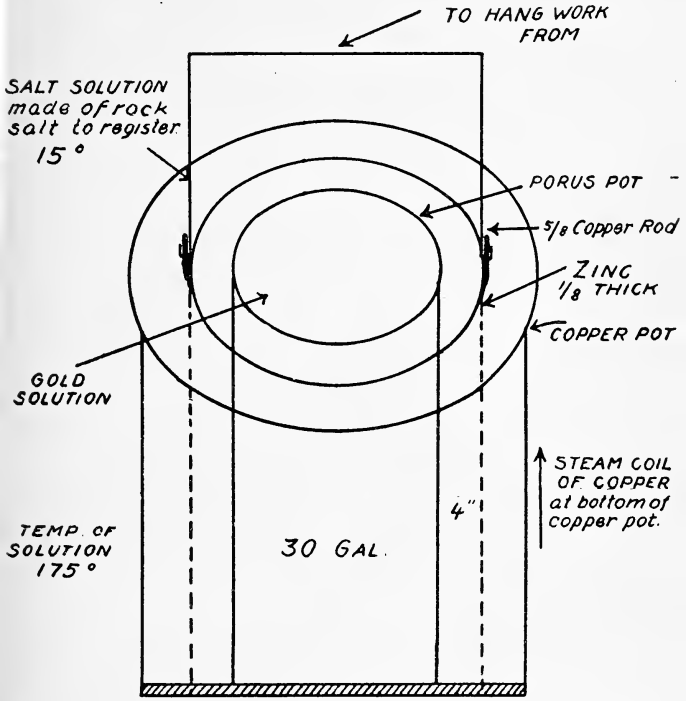


Fig. 13—The Outfit for Salt Water Gilding

SOME TALK ON LACQUER.

First be sure the work to be lacquered has been thoroughly cleaned. Then a room free from dust should be fitted up with an oven

heated to 140° F. and supplied with a chimney or some means of carrying off the fumes of the lacquer, which are very disagreeable.

For dip lacquering the lacquer is placed in an iron enameled vat. The articles perfectly clean are hung on hooks and dipped into the vat and held up for a few minutes to allow the superfluous liquid to run off. Then they are hung up to dry in the oven. Dip lacquers are best thinned at night which will allow time to thoroughly blend. It is impossible to use a single solvent for an all around lacquer. Dip work requires one rate of evaporation, and spray work another rate. This is regulated by the solvents used, and the proportions of each and only experience can teach it. Brush lacquer is the same as dip lacquer except that it should be used with a thicker body so it will spread well under the brush. A fitch or camels hair brush should be used.

The proper preparation of lacquer solvents calls for the highest degree of skill and care. The solvents must be prepared water white and free from water and acid. Lacquer will attract moisture from the air in a damp room, and thus cause considerable trouble. Lacquered work which is thoroughly dried in an oven will be softened up again if a lot of newly lacquered work is put in with it.

For work that requires a heavy coat of high gloss lacquer, additions of various gums are

made, some for hardness, some for gloss, and some for adhesion. Each in its proper proportion, and each with a certain amount of proper solvent to carry it. Some solvents precipitate some gums, and their relative evaporating points are to be considered. Gum lac-

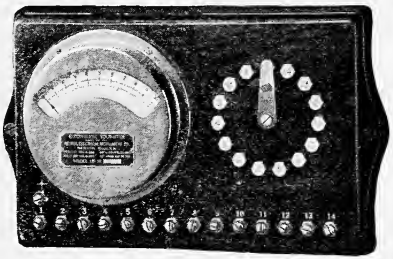


Fig. 14—Rheostat and Wattmeter
Manufactured by Western Electric Company
New York and Chicago

quers unless a very heavy coat is required may be thinned out with three or four parts of thinner. If heavy coats are required they should be dried with considerable heat to harden them. A thoughtful, careful workman will obtain far better results with a fair grade of lacquer, than a careless workman will with the best grade.

THE USE OF WATER DIP LACQUERS.

This name is applied for the reason that after the article has been plated and without drying it can be dipped into the lacquer with-

out in any way injuring the finish. These lacquers are very beneficial for bright dipped finishes that are used in basket work. Also mat finish work on sheet brass, etc. Such work would tarnish at once if dried and then lacquered, and for this reason must be lacquered as soon as the dipping method is over.

For instance, sheet brass that is to be mat finished and dipped through bright dip often causes lots of trouble if you stop to dry it before lacquering. On the other hand if you dip this work through hot soap water and clean hot water, and then dip into lacquer, you will have no trouble whatever. The dip lacquer for this class of work should be used very thin so it will run off without leaving a drip. I have lacquered thousands of pieces of this class of work in this way, and have had very good results.

The water should be removed every day either by syphon, or by means of a faucet at the bottom of tank. A wire screen nickel plated with a coarse mesh should be placed a few inches from the bottom of lacquer tank. All dirt, etc., carried into the lacquer will sift through the screen, and can be drawn off with the water.

BURNISHING WITH STEEL BALLS.

This method of burnishing small metal articles in tumbling barrels is a method of mixing articles such as buckles, chains, collar but-

tons, etc., with steel balls in the proper proportion and rolling together in a soap solution. The balls required must be hard and

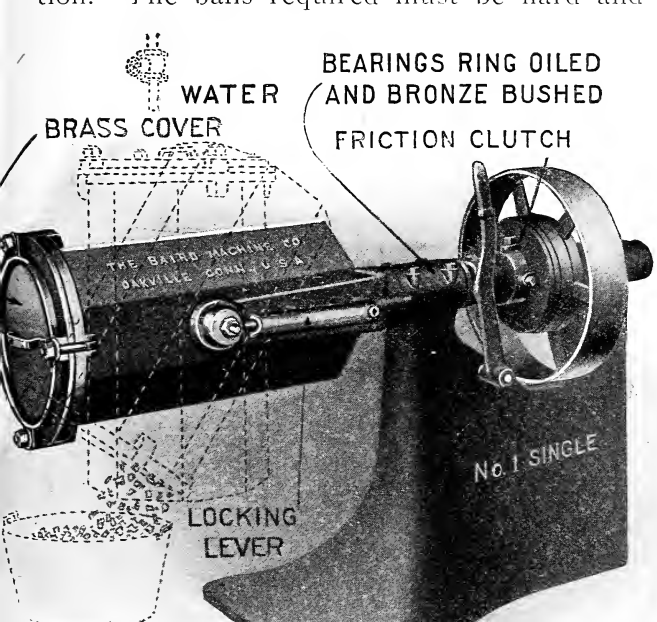


Fig. 15—Steel Ball Burnishing Barrel (Single)
The cut shows barrel in position for working.
Made by The Baird Machine Company, Bridgeport, Conn.

smooth. Any non-alkali soap will do. Small articles can be burnished and handled in large quantities in this way at a very small expense.

I have burnished rose and green gold buckles in this way when I only wanted them to be burnished on the high lights and by tumbling them thirty minutes I got out very

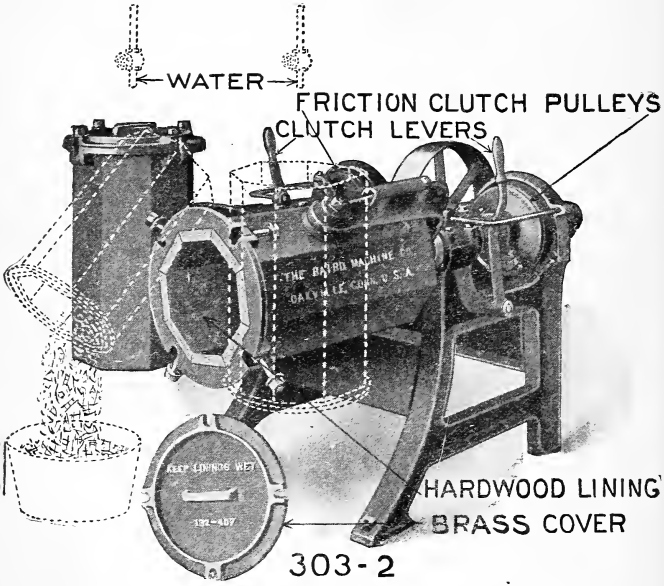


Fig. 16—Double Burnishing Barrel for use with steel balls
Manufactured by The Baird Machine Company, Bridgeport, Conn.
The cut shows one Barrel horizontal and the other in position for dumping

near the same class of work as I would had they been hand burnished, and the cost when the work is handled in this way is very small.

Care should be taken not to allow the steel balls to become rusty.

CHEMICALS USED IN PLATING ROOM.

Sulphuric Acid,
Nitric Acid,
Muriatic Acid,
Citric Acid,
Boracic Acid,
Arsenious Acid,
Hydrofluoric Acid,
Bichromate of Potash,
Caustic Potash or Potassium Hydrate,
Cyanide of Potassium,
" " Silver,
" " Copper,
" " Zinc,
Sodium Carbonate,
" Bicarbonate,
" Bisulphite,
" Hyposulphite,
" Nitrate,
" Phosphate,
" Chloride, or Common Salt,
Sodium Cyanide,
Barium Sulphide,
Ammonium "
Hydrosulphuret Ammonium,
Ammonium Chloride,
" Hydrate,
Yellow Prussiate of Potash, or
Potassium Ferrocyanide,
Sodium "
Barium "
Acetic Acid,
Ammonia,
Caustic Soda or Sodium Hydrate,
Potassium Sulphuret,
Copper Chloride,
" Carbonate,
" Sulphate,
" Acetate,
" Nitrate,
Zinc Carbonate,
" Sulphate,
" Chloride,
Nickel Carbonate,
" Sulphate,
" Chloride,
" Ammonium Sulphate,
Iron Sulphate,
" Chloride,
Sesquichloride of Iron,
Nitrate of Tin,
Tin Chloride, or Muriate of Tin,
Gold Chloride,
Silver "
Platinum "
Silver Nitrate,
Lead "
" Acetate,
Lye or Potash,
Kalye,
Calcium Choride.

THE USES OF AIR BRUSHES.

The most up-to-date method of lacquering at the present time seems to be with the air brush called the "Sprayer," which is operated by compressed air, and everything from the largest to the smallest object can be lacquered or painted by means of this "Sprayer."

There are all styles of sprayers, some for lacquers and some for enamels, etc., and any

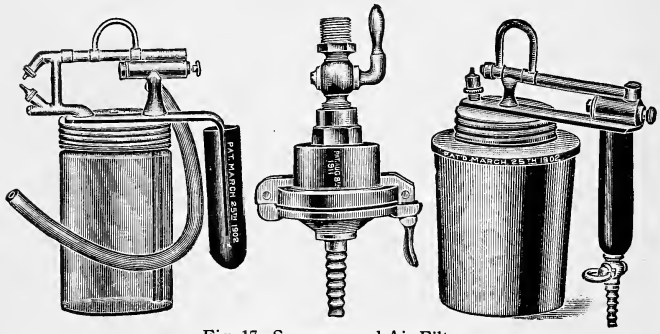


Fig. 17—Sprayers and Air Filter
Made by Eureka Pneumatic Spray Co., New York

number of colors can be blended together by use of the air brush. This method is far superior to the old way of using a camels hair brush. The lacquer or enamels spread better and you can obtain a smoother surface. It also saves labor, as more work can be turned out in this way. Four or five pieces of work can be turned out with the spray while you are doing one with a brush, and at the same time you have better results. It is a very

good idea to use a hood, paint receiver and exhaust fan in connection with the "Sprayer" to remove the vapors which may arise. A pressure regulator and filter are also beneficial for fine work.

FORMULAS.

Gun Metal Finish.

On dip brass, copper, german silver, etc., or on any metal:

Make a saturated solution of cyanide of potassium and arsenic, and use iron anodes and ordinary current.

To make this solution, boil the arsenic and cyanide together in about 2 gallons of water to 2 pounds of cyanide and 1 pound of arsenic, which will when dissolved, be about saturated. If not, add a little more arsenic. Do not inhale the fumes as they are very poisonous.

Acid Copper Solution:

Water	1 Gallon.
Sulphate of copper..	32 Ounces.
Sulphuric acid.....	2 "

Steel Color on Brass.

Muriatic acid.....	1 Quart.
Iron filings or chips.	1 Handful.
White arsenic	1 Tablespoonful.
Water	1 Gallon.

Use hot.

FORMULAS.

Dark Brown Drab on Copper.

Sulpho Cyanide of potash	2	Pennyweights,
Nitrate of iron	5	"
Water	1	Gallon.

Red Copper Solution:

Water	15	Gallons.
Prepared red copper	10	Pounds.
Cyanide of potassium	12	"
Bisulphite of soda	10	"

Brass Solution:

Carbonate of copper	10	Ounces.
" " zinc	5	"
Bisulphite of soda	10	"
Cyanide of potassium	30	"
Water	5	Gallons.

A small amount of ammonia and arsenic.

Cyanide Copper Solution:

Carbonate of copper	5	Ounces.
Bisulphite of soda	2	"
Cyanide of potassium	10	"
Water	1	Gallon.

Royal Copper:

Red lead	1	Pound.
Banner lye	2	"

Boil above 20 minutes in 1 gallon of water and add it to 10 gallons of water. Use copper anode. Rinse and heat until work becomes a cherry red, and develop color by buffing. Use a hard metal, copper preferred.

FORMULAS.

Tin Solution:

Muriate of tin..... 6 Ounces.
Phosphate of soda... 6 "
Acetic acid..... 2 "
Water ..... 1 Gallon.

Use pure tin anode and low voltage. Acetic acid hardens deposit.

Galvanizing Solution:

Water ..... 1 Gallon.
Sulphate of zinc.... 2 Pounds.
" " alum'm 1½ Ounces.
Zinc anodes.

Strip for Brass, Copper or German Silver:

Oil of vitriol..... 5 Gallons.
Nitric acid.....10 Ounces.

Use hot and remove work as soon as stripped. When acid is saturated, dilute six times its volume with water, and precipitate with salt water.

Gold Precipitate:

After cutting gold with aqua regia, precipitate with aqua ammonia, (aqua regia is)
Nitric acid.....1 part.
Muriatic acid.....3 "

To Dissolve Arsenic:

Arsenic can be dissovlved in small quantities in the following alkalies and acids, readily if hot, and slowly if cold:

FORMULAS.

Nitric acid	Ammonia
Sulphuric acid	Cyanide of potassium
Acetic acid	Caustic potash
Muriatic acid, Etc.	Carbonate of soda,
Banner	lye, etc.

Hydrosulphuret of Potash:

Caustic potash..... 8 Ounces.
Pulverized sulphur..16 "
Water ..... 1 Quart.

Boil one hour. After cooling, filter and use the clear liquid only. Add warm water, as it boils away. It will turn a deep red color.

Quick Electrotype:

Fine copper bronze
powder ..... 1 Ounce.
Plumbago ..... 1 "

Rub above mixture on cast until a fine surface is presented, and plate in acid copper solution.

Bright Pickle for Iron:

Water ..... 1 Gallon.
Sulphuric acid .....12 Ounces.
Zinc ..... 1 Ounce.
Nitric acid ..... 5 Ounces.

Black Nickel Solution:

Take (10) gallons of regular nickel solution (double sulphate of nickel and ammonia) standing 6° Bé, and add (1) pound sulphocyanide of potassium and half a pound (½ lb.) C. P. sulphate of zinc. Use old anodes

FORMULAS.

and a current of about ¾ volts. Have the solution decidedly alkaline with ammonia. The zinc sulphate can be precipitated with sal soda and washed thoroughly, then dissolved in strong ammonia. The latter method will make the solution sufficiently alkaline. A small amount of aluminum sulphate added to this solution will improve it.

Gold Strip:

Sulphuric acid C. P. .. 1 Pound.
Hydrochloric acid C. P. 2-2/3 Ounces.
Nitric acid 40° Bé..... 1¼ Ounces.
Keep free from water.

Soldering Acid:

Cut zinc with muriatic acid to saturation, and evaporate to 1/3 by boiling, and allow to cool, and then add an equal volume of saturated sal ammoniac solution, and add about 10% crude glycerine. The boiling prevents sputtering when using. The glycerine prevents discoloration of work.

Green Gold Solution:

Water ..... 1 Gallon.
Gold as fulminate .... 4 Pennyweights.
Nitrate of silver ..... 1 Pennyweight.
Cyanide ..... 1 Ounce.

Blue Oxidize on any Metal:

Nitrate of lead ..... 4 Ounces.
Nitrate of iron ..... 2 Ounces.

FORMULAS.

Hyposulphite of soda..16 Ounces.
Water ..... 5 Gallons.
Use hot.

Blue Color on Steel:

Heat steel to straw color and plunge into common machine oil. The work will take on a beautiful blue color.

Flux for Melting Silver:

Bicarbonate of soda. 1 Pound.
Cream of tartar..... 1¼ "
Silver ..... 1 "

Dip Gold Solution:

Water ..... 1 Gallon.
Yellow prussiate of potash .....12 Ounces.
Phosphate of soda ....10 Ounces.
Sesquichloride of iron.. 2 Ounces.
Fulminate of gold .... 5 Pennyweights.
Solution must be kept in iron kettle and boiling when in use.

Verde Green Solution:

Water ..... 3 Quarts.
Chloride of calcium... 4 Ounces.
Chloride of ammonia.. 4 Ounces.
Nitrate of copper ..... 4 Ounces.
Brush on work and stipple.

Acid Dip for Mat Finish on Brass:

Nitric acid ..... 1 Part.
Oil of vitriol ..... 2 Parts.

FORMULAS.

Add Sulphate of zinc to full saturation. If mat finish is too coarse, add more oil of vitrol, if too fine, add nitric. Use hot and keep water out of dip as much as possible.

Fine Brown Bronze on Copper:

Nickel-ammonium sulphate (Double nickel salts)	12 Ounces.
Copper sulphate	2 Ounces.
Water	2 Gallons.

Use hot. Dip work in solution two or three minutes, take out, rinse in clean water, scratch brush with dry brush. If not the color desired, repeat as before.

Barbadienne Bronze:

First, plate object brass, then black nickel.

Second, put on a mixture of sanguine and black lead, equal parts, and enough gum arabic to make it stick, say about a wineglass full of gum arabic to a pint of water, and enough of water to make a very thin mixture.

Third, take equal parts of sanguine and pale gold bronze, mix very fine by grinding. If that does not give the desired shade add more of either color and nothing else. Use good varnish relief as for any bronze.

Flux to Clear Chloride of Silver of Chlorine:

Add to chloride of silver in crucible before melting, 40% of calcined soda. Calcined soda is made by heating sal soda on a hot surface until it is dry, and in a fine powdery form.

FORMULAS.

To Crystallize Tin:

Bring the tin article to a straw color by heating with blow pipe, and at once spray with cool water, and then plunge it into dilute sulphuric acid, which will bring out the crystals.

A Simple Method for Testing Silver Solution for Silver:

Take 4 ounces of silver solution to be tested, and precipitate with hydrochloric acid. If copper be present, it can be cut out easily with nitric acid. The nitric will not cut the silver After the silver has gone to the bottom, draw off the fluid and place a small piece of zinc in the silver, which will with the acid or a few drops of sulphuric acid, drive out all chlorine and cyanogen, leaving it a dark colored pure silver which must be dried and weighed, which will give the true amount of silver per gallon of solution by multiplying by 32 the amount of silver found in 4 ounces of solution, as there are 128 ounces to a gallon, and we take 4 ounces of solution, so we multiply by 32 which gives the number of ounces per gallon.

Note: This method with proper manipulation will give pretty near perfect results.

FORMULAS.

To detect Iron in Sulphate of Copper:

Dissolve sulphate of copper with ammonia to excess, which will redissolve the copper, and if iron be present it will remain at the bottom as hydrate of iron.

Paint for Sectional Gold:

Take gumquac and break with a hammer until it is in powder form, and then dissolve in wood alcohol and let stand 24 hours. Then strain through cheese cloth, and add any desired aniline color. Remove with lye or potash.

Another very good stop-off is

Collodion ..... 1 Part.
Lacquer ..... 1 Part.

Remove with lacquer thinner.

Terra Cotta Bronze:

Red sulphide of arsenic. ¾ Ounce.
Pearl ash ..... 6 Ounces.
Water ..... 1 Gallon.
Sulphuret of potash ... 3 Pennyweights.

Use boiling hot.

Jet Black on Copper.

Water ..... 3 Gallons.
Pulverized sulphur .... 9 Ounces.
Caustic Potash ..... 1 Pound.

Boil until sulphur is all dissolved, then filter and add to 20 gallons of water. Use cold on copper, and scratch brush work before immersion. Finish on soft rag wheel with kerosene and rouge.

FORMULAS.

Silver Solder:

Sterling silver .....40 Parts.
Brass .....30½ "

Bronze Solution:

Water ..... 1 Gallon.
Cyanide of potassium.. 6 Ounces.
Bisulphite of soda..... 2 Ounces.
Carbonate of copper .. 4 Ounces.
Chloride of tin.....½ Ounce.
Use bronze anodes.

Black Nickel Solution:

Water ..... 1 Gallon.
Nickel-ammonium sulphate (Double nickel salts) .....12 Ounces.
Sulpho cyan potash ... 3 Ounces.
Carbonate of copper... 2 Ounces.
White arsenic ..... 2 Ounces.

Dip Silver Solution:

Water ..... 1 Gallon.
Cyanide of potassium.. 2 Pounds.
Caustic potash .....½ Pound.
Chloride of silver..... 1 Ounce.
Stir well and use hot.

Royal Copper Solution:

Red lead .....½ Pound.
Caustic stick potash ...½ Pound.
Water ..... 5 Gallons.
Use pure lead anodes.

Note: Copper plate work and then run in above solution for a couple of minutes, and then heat with blow-pipe flame and buff with red rouge.

FORMULAS.

Black Nickel Smut for French Grey:

Oxide of nickel ..... 5 Pounds.
Carbonate of copper... 1 Pound.
Sal soda .....100 Pounds.
Water .....150 Gallons.
Carbonate of ammonia. 5 Pounds.
Dissolve the copper and nickel in the ammonia.

Verde Antique Paint.

Chrome green,
" yellow,
Zinc white,
A very little yellow ocher. Mixed to desired consistency with turpentine.

Dip Black on Brass.

Water ..... 1 Gallon.
Carbonate of soda..... 4 Ounces.
Carbonate of copper .. 1 Pound.
Ammonia ..... 1 Quart.
Use hot or cold.

Crystallized Tin:

Dip tin goods in a hot solution of water and sesquichloride of iron.

To Separate Silver Metal from Copper:

Cut the combination metals with nitric acid, and then precipitate with hydrochloric acid, which will throw the silver to the bottom as chloride, and hold the copper in the solution as chloride.

FORMULAS.

To Recover Gold from an Old Solution:

Place a quantity of scrap turnings or filings of zinc in the solution which will collect all the gold, after which draw off the solution, and then cut the zinc with hydrochloric acid, leaving the gold at the bottom.

Note: Cyanide of silver is not soluble in nitric acid unless heated. Cyanide of copper is soluble in nitric acid cold or hot.

To remove fire stain from Sterling Silver:

Nitric acid ..... 1 Part.
Water ..... 1 "
Use hot.

To strip Silver from Steel:

Water ..... 1 Gallon.
Cyanide of potassium.. 8 Ounces.
Chloride of silver .... ½ Ounce.
Use reverse current.

Stop-Off or Paint for Etching:

Virgin rubber dissolved with benzine. Add a small amount, say ¼ ounce of asphaltum to a tablespoonful of virgin rubber. Cut the asphaltum with turpentine, and add the rubber when dissolved to the asphaltum. This is strictly acid proof.

FORMULAS.

Color Mixing Paints, Inks, etc.

Red and black make brown,
Lake and white make rose,
White and brown make chestnut,
White, blue and lake make purple,
Blue and lead color make pearl,
White and carmine make pink,
Indigo and lamp black make silver gray,
White and lamp black make lead color,
Black and venetian red make chocolate,
Purple and white make French white,
Light green and black make dark green,
White and green make pea green,
White and emerald green make brilliant green,
Red and yellow make orange,
White, lake and vermillion make flesh color,
Umber, white and venetian make drab,
White, yellow and venetian red make cream,
Blue, black and red make olive,
Yellow, white and a little venetian red make buff,
White and green make bright green,
White, blue and grey make pearl grey.

ACID COPPER PLATING SOLUTION.

Standard Formula:

Crystallized copper sulphate. 32 Ounces.
Water ..... 1 Gal. (U.S.)

Copper Determination:

Put 5 c.c. of the solution using a pipette, into a 250 c.c. beaker. Add about 100 c.c. water and 25 c.c. conc. sulphuric acid. Cut off a

small strip (about 1½ inches square) of aluminum foil and place it in beaker. Heat gently and the copper will be precipitated out as metallic copper. When solution becomes white, the copper can be filtered off using glass wool in funnel in place of filter paper. The filtrate is tested for copper by passing in H_2S gas, which gives a black precipitate of copper sulphide if it is present, indicating that it was not all precipitated by the aluminum foil. Wash the copper on the funnel once with hot water, then dissolve off the copper from the aluminum foil with warm conc. nitric acid pouring into funnel and receiving the dissolved copper in an Erlenmeyer flask. When all the copper is dissolved, the solution is heated until all nitrous fumes are gone, then add ammonium hydrate in slight excess and evaporate until most of the free ammonia has disappeared. Acetic acid is added in excess and heated. If solution is not clear it should not be heated too much as some of the copper will be lost by volatilization. When all the copper is in solution cool and add ten grams potassium iodide. making sure that all of it is dissolved before beginning titration. The free iodine that is liberated in the reaction is titrated with standard sodium thiosulphate solution, using starch as an indicator. The reaction between the copper acetate and potassium iodide is the formation of copper iodide and the liberation of iodine:

When the potassium iodide is added a yellow precipitate of cuprous iodide ($Cu_2 I_2$) is thrown down. The starch is not added until towards the end of the titration. It produces a lilac color and the potassium thiosulphate solution is added slowly until one or two drops shows a change to a cream which remains permanent and is not changed by the addition of more sodium thiosulphate solution.

Calculation:

Multiply the number of c.c. of sodium thiosulphate used by the copper sulphate (Cu S $O_4$5 H20) value for 1 c.c., then divide by 5. The result is multiplied by 133.54 which gives ounces (av.) of copper sulphate per gallon (U. S.)

The following example will illustrate it:

Used 61.0 c.c. sodium thiosulphate solution, the copper sulphate value for 1 c.c. is .01964. This multiplied by 61 will equal 1.19804, then divided by 5 will equal .2396; multiply this by 133.54 will equal 32 ounces of copper sulphate (Cu S O_4) 5 H_2O) per gallon.

Standard sodium thiosulphate:

Dissolve 39.2 grams of C. P. sodium thiosulphate in water and dilute to two liters. This solution is quite stable. A slight decomposition might occur soon after making the solution due to carbon dioxide or oxygen in the water. The solution should be kept in a brown bottle as actinic light will decompose

it. To standardize, take one gram of pure copper foil and dissolve in about 20 c.c. dilute nitric acid. When dissolved, dilute to 250 c.c. Then take out 50 c.c. with pipette (this is equivalent to .2 grams of copper) into an Erlenmeyer flask. Boil out nitrous fumes; then add ammonium hydrate in slight excess and evaporate until most of the free ammonia has disappeared. Acetic acid is added in excess and heated if solution is not clear. When all the copper is in solution, cool and add ten grams of potassium iodide. Then titrate with the sodium thiosulphate solution. The end point obtained when standardizing should be remembered and be the same when titrating samples.

The number of c.c. of sodium thiosulphate used is divided into .2 grams, and the result will be the number of grams of copper per c.c., and this multiplied by 3.9283 will give the copper sulphate ($Cu\ S\ O_4\ 5\ H_2O$) value of 1 c.c. of the solution.

Starch Solution:

Mix 0.25 gram of potato starch with 10 c.c. cold water; then add to boiling water with constant stirring to make about 400 c.c. When cold, use about 1 c.c. for titrating. It decomposes very readily and should be prepared fresh every day. It produces an intense blue with iodine, and if brownish red indicates decomposition. The following are the reactions that occur:

Copper acetate reacts with potassium iodide liberating free iodine as follows:

$2\ Cu\ (C_2\ H_3\ O_2)_2 + 4K\ I = Cu_2\ I_2 + 4\ (K\ C_2\ H_3\ O_2) + 2\ I$

The free iodine colors the solution brown. The iodine reacts with the sodium thiosulphate forming sodium iodide and sodium tetrathionate.

$2\ Na_2\ S_2\ O_3 + 2\ I = 2\ Na\ I + Na_2\ S_4\ O_6.$

The blue compound that is formed when starch is mixed with iodine is of unknown composition. It behaves towards sodium thiosulphate exactly as free iodine, and the reaction occurs as in the above equation.

Sulphuric Acid determination:

Measure out 5 c.c. of the solution with pipette into a 400 c.c. beaker; add 100 c.c. water and about 1 drop of a 5% solution of methyl orange. The solution will be a bright red. Place beaker on a white surface. From a 50 c.c. burette add $\frac{N}{1}$ — sodium hydrate until solution in beaker becomes a golden yellow. This indicates the end point. The number of c.c. used of the $\frac{N}{1}$ — sodium hydrate is noted and calculated as follows:

The number of c.c. $\frac{N}{1}$ — sodium hydrate used

is multiplied by the sulphuric acid value of 1 c.c. (exactly $\frac{N}{1}$ Na O H will be .04904 grams) then divided by 5, and the result multiplied by 133.54 will give ounces (av.) of sulphuric acid (100% per gallon (U. S.).

Example:

Used 8.0 c.c. $\frac{N}{1}$ Na O H. The sulphuric acid value of 1 c.c. is .04904. Multiply this by 8 will give .39232 and divided by 5 will equal .07846; then multiply by 133.54 will give 10.48 ounces (av.) of sulphuric acid per gallon (U. S.).

Standard $\frac{N}{1}$ Sodium Hydrate:

Dissolve 80 grams C. P. sodium hydrate in water and dilute to two liters. Standardize with $\frac{N}{1}$ sulphuric acid, using methyl orange as an indicator.

1 c. c. exactly $\frac{N}{1}$ Na O H = .0400 grams

1 c. c. " " = .04904 grams $H_2 S O_4$.

The following reactions occur in titrating:

$H_2 S O_4 + 2 Na O H = Na_2 S O_4 + 2 H_2 O$

Methyl orange is changed by alkalies to a yel-

low and by acids to a pink red, therefore in titrating acidity it will indicate when sufficient sodium hydrate has been added, as an excess will change color to a yellow.

Copper Determination:

Put 10 c.c. of the solution with a pipette into a 250 c.c. beaker. Add 15 c.c. conc. H Cl, Care should be taken not to inhale the gas, as it is very poisonous. Boil a few minutes then add 5 c.c. $H_2 O_2$ and continue boiling for fifteen minutes, adding water occasionally for the loss by evaporation. After decomposition of the cyanide 100 c.c. water are added and solution heated, then H_2 S gas passed in for about ten minutes to precipitate the copper as Cu S. After precipitation, place beaker on water bath until precipitate collects and falls to the bottom, then filter it off washing with H_2 S water three or four times. The filtrate is set aside for zinc determination. The filter paper containing the copper sulphide is removed from the funnel and the sulphide washed into a 250 c.c. beaker. The small portions that cannot be removed by washing can be dissolved by pouring on conc. nitric acid, adding sufficient finally to dissolve all of the Cu S. Boil out excess of H N O_3 and filter off any sulphur that has collected in small yellow lumps. Filter into an Erlenmeyer flask and neutralize with N H_4 O H, adding slight excess; then boil until N H_4 O H is faint. Add excess of acetic acid and boil for a couple of

minutes until all the copper salts are in solution. Cool to the ordinary temperature (to prevent volatilizing free iodine) and add 10 grams of K I. The free iodine is titrated with standard sodium thiosulphate solution until the brown tinge has become faint then add sufficient starch solution to produce a decided blue color the titration is continued with vigorous shaking until a permanent cream color is produced. The starch solution should be weak as otherwise it tends to occlude iodine forming very small lumps that are not readily acted on by the thiosulphate solution. About .25 gram in 400 c.c. of water is the correct strength to use.

BRASS PLATING SOLUTION.

Standard formula:

Dry copper carbonate	12 Ounces.
Dry zinc carbonate	7 Ounces.
Potassium cyanide	25 Ounces.
Water	1 Gallon.

Calculation:

Multiply the number of c.c. of sodium thiosulphate used by the copper value for 1 c.c. ($Cu\ C\ O_3\ Cu\ (OH)_2\ H_2\ O$). The formula difbonate as figured from its theoretical formula multiply by 1.8812. This will give copper cargallon. To convert this to copper carbonate. Then divide by 10. The result multiplied by 133.54 will equal ounces (av.) of copper per fers according to the method of manufactur-

ing the copper carbonate. A true basic copper carbonate having the above formula would analyze as follows:

Cupric oxide	(Cu O)	66.54
Carbon dioxide	(CO_2)	18.40
Water	(H_2O)	15.06
		100.00

Sodium Thiosulphate:

Use the same solution as is used for acid copper. The copper carbonate (Cu C O_3 Cu $(OH)_2$ H_2O

Value for 1 c.c. is found by multiplying the copper value by 1.8812 or to find any other value multiply by the following factors:

Cu $\times$ 1.2517 = Cu O
Cu O $\times$ 0.7989 = Cu
Cu $\times$ 1.8812 = Cu C O_3 Cu $(OH)_2$ H_2O

Zinc Determination:

The filtrate from the Copper Sulphide is boiled to expel H_2S, then neutralized with N H_4 O H. Add 10 c.c. conc. H Cl and 5 grams of ammonium chloride and dilute to 250 c.c. Heat solution nearly to boiling, then take out a portion, about 50 c.c. into another beaker; run into the remaining portion with vigorous stirring standard potassium ferrocyanide solution until a brown tinge is produced, when a few drops is taken out on a porcelain plate and mixed with a solution of uranium acetate. The portion that was taken into the beaker is then added in

small portions at a time continuing the titration after each portion is added. After the addition of the last portion the ferrocyanide solution is added by drops until the end point is obtained as a brown color with the uranium acetate. A correction for the reaction with the indicator, having the same conditions as above—that is, volume, temperature, ammonium chloride and free acid, but without the zinc—is determined. This correction, which will not amount to more than a few tenths of a c.c., is always subtracted from the burette reading when a titration is made.

Calculation:

Multiply the number of c.c. of potassium ferrocyanide solution used by the zinc value for 1 c.c. then divide by 10. The result multiplied by 133.54 will equal ounces of zinc per gallon. To convert this to zinc carbonate: ($5\ Zn\ O.\ 2\ C\ O_2\ 4\ H_2O$),
multiply by 1.7345.

Basic zinc carbonates differ in composition like the copper carbonate according to the method of manufacture. The true basic zinc carbonate has the above formula and would test as follows:

Zinc oxide	($ZN\ O$)	71.77%
Carbon dioxide	($C\ O_2$)	15.52%
Water	($H\ O_2$)	12.71%
		100.00%

Potassium Ferrocyanide:

48.6675 grams of Merck's pure potassium ferrocyanide are dissolved in water and made up to 2250 c.c. and kept in a brown bottle.

Uranium Acetate:

Dissolve 4.4 grams of Merck's salt in 100 c.c. of water and 2 c.c. of acetic acid.

Standardizing the potassium ferrocyanide solution:

0.3 grams of Merck's pure zinc are dissolved in 25 c.c. of dilute H Cl (1 part H Cl, 3 parts H_2O), then add 4 grams of pure N H_4 Cl and dilute to 250 c.c. with water and heat almost to the boiling point. Then run in about 58 c.c. of the potassium ferrocyanide solution, stirring vigorously. Take out two or three drops on a plate covered with parafine and mix with a drop or two of the uranium acetate solution. Continue the titration until the first faint tinge of brown red color. Another portion of 0.3 grams of zinc is also titrated and should agree with the first portion within 0.1 c.c. A correction for the reaction, having the same volume of H_2O, H Cl, and same number of grams of N H_4 Cl but without the zinc, is determined. This correction is deducted from the number of c.c. used in titrating the 0.3 grams sample.

To find the value of 1 c.c. of potassium ferrocyanide solution in terms of zinc, divide 0.3 by the corrected c.c. of the ferrocyanide

used and the result will be the grams of zinc in 1 c.c. of the potassium ferrocyanide solution. To find the value in terms of zinc oxide or carbonate, multiply the zinc value by the following factors:

$Zn \times 1.2448 = Zn\,O$

$Zn\,O \times 0.8034 = Zn$

$Zn \times 1.7345 = 5\,Zn\,O.\ 2\,C\,O_2.\ 4\,H_2O$

The reactions that occur in titrating between zinc chloride and potassium ferrocyanide vary according to temperature, quantity of solution, and amount of acid.

The probable reactions, using the above methods, are as follows:

$$4\,Zn\,Cl_2 + 2\,K_4\,Fe\,(C\,N)_6 = 8\,K\,Cl + 2\,Zn_2\,Fe\,C\,N_6$$

A secondary action then takes place:

$$6\,Zn_2\,Fe\,(C\,N)_6 + 2\,K_4\,Fe\,(C\,N)_6 = 4\,K_2\,Zn_3\,(Fe\,(C\,N)_6)_2.$$

RESULTS OBTAINED BY ANALYSIS OF BRASS SOLUTION.

In making up a brass solution, put in the metal at the rate of 5 parts carbonate of copper, and 3 parts carbonate of zinc. One would naturally think when a test was made of this solution that the same proportion of copper and zinc would be found, but I find that when an analysis is made the proportions are quite different, as there is always a sediment in the bottom of a brass solution, and this sediment in my experience is mostly zinc, with a very small amount of copper. So do not run away

with the idea of being able to test your solution and get the same amount as you weighed and put in, as it seems to be impossible to make a brass solution and take up all the metal. For instance try and make up a standard brass solution, and that will show you that it is next to impossible to take up all the metal. I find the best way is to take a small amount of solution from the top of one of the tanks which is clear, and then standardize it by analysis, which will prove to you the true amount of metal in the solution.

For example, make up a solution of

12 Ounces copper carbonate,
6 Ounces zinc carbonate.

and then you say to yourself, I have a solution with the above named amounts in it, you are wrong as a good part of the compound is lying on the bottom of the tank, and is not in solution.

CYANIDE COPPER PLATING SOLUTION.

Copper Determination:

Take 10 c.c. of the solution with a pipette into a 250 c.c. beaker. Add 15 c.c. conc. H Cl. Care should be taken not to inhale the gas, as it is very poisonous. Boil a few minutes, then add 5 c.c. H_2O_2 and continue boiling for fifteen minutes, adding water occasionally for the loss by evaporation. After decomposition of the cyanide 100 c.c. of water is added and solution heated, then H_2S gas passed in

for about ten minutes to precipitate the copper as Cu S. After precipitation place beaker on water bath until precipitate collects and falls to the bottom, then filter it off washing with H_2S water three or four times. The filter paper containing the copper sulphide is removed from the funnel and the sulphide washed into a 250 c.c. beaker. The small portions that cannot be removed by washing can be dissolved by pouring conc. nitric acid adding sufficient finally to dissolve all of the Cu S. Boil out excess of H N O_3 and filter off any sulphur that has collected in small yellow lumps. Filter into an Erlenmeyer flask and neutralize with N H_4 O H, adding slight excess; then boil until N H_4 O H is faint. Add excess of acetic acid and boil for a couple of minutes until all the copper salts are in solution. Cool to the ordinary temperature (to prevent volatilizing free iodine) and add 10 grams of K I. The free iodine is titrated with standard sodium thiosulphate solution until the brown tinge has become faint, then add sufficient starch solution to produce a decided blue color. The titration is continued with vigorous shaking until a permanent cream color is produced. The starch solution should be weak, as otherwise it tends to occlude iodine, forming very small lumps that are not readily acted on by the thiosulphate solution. About .25 gram in 400 c.c. of water is the correct strength to use.

Calculation:

Multiply the number of c.c. of sodium thiosulphate used by the copper value for 1 c.c. Then divide by 10. The result multiplied by 133.54 will equal ounces (av.) of copper per gallon. To convert this to copper carbonate multiply by 1.8812. This will give copper carbonate as figured from its theoretical formula ($Cu\ C\ O_3\ Cu\ (OH)_2\ H_2O$). The formula differs according to the method of manufacturing the copper carbonate. A true basic copper carbonate having the above formula would analyze as follows:

Cupric oxide	($Cu\ O$)	66.54
Carbon dioxide	($C\ O_2$)	18.40
Water	(H_2O)	15.06
		100.00

Standard Solutions:
Sodium Thiosulphate:

Use the same solution as is used for acid copper. The copper carbonate ($Cu\ C\ O_3\ Cu\ (O\ H)_2\ H_2O$

Value for 1 c.c. is found by multiplying the copper value by 1.8812, or to find any other value multiply by the following factors:

$Cu \times 1.2517 = Cu\ O$
$Cu\ O \times 0.7989 = Cu$
$Cu \times 1.8812 = Cu\ C\ O_3\ Cu\ (OH)_2\ H_2O$

ASSAY TEST OF GOLD IN GOLD PLATING SOLUTIONS.

Apparatus Necessary:

Evaporating Dish,
Crucible,
Gas furnace,
Cupel mould,
Balance,
100 c. c. Graduated flask.

Chemicals:

Sodium bicarbonate,
Lead oxide,
Argol,
Bone ash.

75 c.c of the solution is taken and evaporated to dryness in an evaporating dish. The residue is scraped off and put in a crucible (any good sand or clay crucible about 4½ inches in height will do) with the following charge:

20 grams $Na\ H\ C\ O_3$ (Sodium bicarbonate)
70 " $Pb\ O$ (Lead oxide)
3 " Argol (Cream of tartar)

The whole is now thoroughly mixed in the crucible. It is now ready for the furnace. The heat is applied slowly at first, gradually increasing till the flux melts. The flux has action and appears to boil mildly. The crucible is left in the furnace about 25 minutes, being occasionally swirled and should not be removed until all action in the crucible has ceased.

It is now taken out, swirled and allowed to cool. When cool the crucible is broken open and a lead button is found in the bottom. This button contains the gold and should be freed from any particles clinging to it by hammering.

A bone ash cupel is now moulded and baked. Cupels are made of bone ash slightly moistened with water so that the powder will cling together. The mixture should be well kneaded before being put in the cupel mould. On coming out of the mould it is slowly baked in the furnace and if possible the cupel should be air dried for a week or so although this is not essential.

The lead button is now put in the cupel and is ready for the furnace. A high heat is maintained for a few minutes in order that the lead may melt quickly and oxidation commence as soon as possible. After the fumes of lead oxide are observed to rise from the surface of the cupel, the heat is moderated and as free a flow of air as possible is given. The lead is lost in the air as lead oxide, and a great deal is absorbed by the cupel. When all the lead is gone the lead loses all lustre. The change of color is readily noticed and the cupel is withdrawn from the furnace with its small bead of gold.

The gold is weighed and the pennyweights per gallon may be calculated as follows:

Weight gold $\times$ 50.33=number grams per gallon.

Grams per gallon of solution.

Grams per gallon ÷ 1.55=pennyweight per gallon.

NICKEL PLATING SOLUTION.

Standard Formula:

Nickel ammonium sulphate (Double nickel salts) .....12 ounces.
Water ..... 1 Gallon.

Nickel Determination:

Measure out 25 c.c. of the solution with pipette into a 250 c.c. beaker. Add about 2 c.c. Conc. sulphuric acid and heat almost to the boiling point. Pass in hydrogen sulphide gas to precipitate any metals such as copper, antimony, tin. If present, the precipitate is filtered off, washing with H_2S water, and after washing thoroughly the filtrate is boiled to expel H_2S. When entirely free from H_2S the iron is oxidized with 5 c.c. of hydrogen peroxide and boiled until the hydrogen peroxide is decomposed (takes about 15 to 20 minutes).

The iron found in nickel salts is an impurity and should be present only as a trace. After boiling about twenty minutes the iron is precipitated with ammonium hydrate filtered and washed once or twice with hot water. The precipitate is dissolved in dilute sulphuric acid (1 part sulphuric acid and three parts water); it is then reprecipitated with ammonium hydrate; the second filtrate is then added to the first. This second precipitation is necessary

with large amounts of iron, as the iron occludes some of the nickel when it is precipitated.

The filtrate is transferred to a 500 c.c. beaker, boiled to expel free ammonia and neutralized with sulphuric acid, using litmus paper as an indicator. When solution is neutral add 2 c.c. Conc. ammonium hydrate and dilute solution to 250 c.c. with water; then cool to 68°F. It is now ready to be titrated with standard potassium cyanide solution as follows: Run into the solution from a 50 c.c. burette 5 c.c. of standard silver nitrate solution (prepared according to directions under standard solutions). Add 0.5 c.c. of a 2% solution of potassium iodide which throws down a precipitate of silver iodide. This precipitate is used as an indicator to show when all of the nickel has combined with the potassium cyanide solution as an excess of potassium cyanide will dissolve it. The beaker containing the solution is placed on a black surface and standard potassium cyanide solution is run in slowly from a 50 c.c. burette until the disappearance of the precipitate of silver iodide. This indicates the end point, but usually an excess of potassium cyanide is used to dissolve the silver iodide, then this excess can be found by running in the silver nitrate until the first appearance of a precipitate; then one or two drops of the potassium cyanide solution should give a very clear solution.

The number of c.c. of silver nitrate and potassium cyanide used is read off and amount of nickel ammonium sulphate calculated as follows:

The c.c. of silver nitrate used is converted into equivalent c.c. of potassium cyanide by a factor found under silver nitrate solution. After multiplying by this factor the c.c. obtained are substracted from c.c. of potassium cyanide used, and the result will be the correct number of c.c. of potassium cyanide used for titrating sample. The nickel ammonium sulphate value on 1 c.c. of the potassium cyanide solution (See potassium cyanide solution for this value) is multiplied by the c.c. of potassium cyanide used, and divided by 25 c.c., then the result multiplied by 133.54 will give the ounces (av.) of nickel ammonium sulphate.

($Ni\ S\ O_4\ (N\ H_4)_2\ S\ O_4 + 6H_2O$) per gallon (U. S.)

The following example will illustrate it:

The factor to convert c.c. of silver nitrate to equivalent c.c. of potassium cyanide was found to be 0.2. Used 30.4 c.c. of silver nitrate, and multiplying by 0.2 will equal 6.08 c.c. potassium cyanide. Ran into the solution 74.88 c.c. of potassium cyanide, then substracting 6.08 will leave 68.8 c.c. of potassium cyanide actually used.

The value of 1 c.c. of potassium cyanide solution in grams of nickel-ammonium sul-

phate was found to be .03265, which multiplied by 68.8 c.c. will give 2.24632, and divided by 25 c.c. will equal .0898, then multiplied by 133.54 will give 12 ounces of nickel-ammonium sulphate per gallon.

Standard Silver Nitrate Solution:

Dissolve 11.6 grams of C. P. silver nitrate in water and dilute to two liters. This solution is to be kept in a brown bottle, as the light will decompose it. To find the factor to give equivalent c.c. of potassium cyanide solution, take 15 c.c. of the silver nitrate, add 2 c.c. Conc. ammonia and dilute with water to 250 c.c. Add 0.5 c.c. of potassium iodide and run in potassium cyanide solution slowly until disappearance of precipitate. The number of c.c. used is divided by 15 c.c., and the result will be the factor to convert c.c. of silver nitrate to c.c. of potassium cyanide.

Standard Potassium Cyanide Solution:

Dissolve 44.5 grams of C. P. potassium cyanide (Merck's Reagent) in water and dilute to two liters. Solution should be kept in a brown bottle and will have to be standardized every few days as it does not remain stable.

Standardize as follows: Weigh 1 gram C. P. nickel (Electrolytic) and dissolve in 5 c.c. of dilute nitric acid and 10 c.c. of dilute sulphuric acid and a little water. When dissolved, transfer to a 250 c.c. graduated flask;

cool, and dilute to 250 c.c. with water. Take out 50 c.c. with pipette which is equivalent to .2 grams of nickel. (50 c.c. is $\frac{1}{5}$ of 250 c.c. and $\frac{1}{5}$ of 1 gram is .2 gram). Neutralize with ammonia; then add 2 c.c. in excess, and titrate with the silver nitrate and potassium cyanide, as in the directions already given. The c.c. of potassium cyanide used is divided into .2 grams, and the result multiplied by 6.7314 will be the nickel-ammonium sulphate ($Ni\ S\ O_4\ (N\ H_4)_2\ S\ O_4\ 6H_2\ O$) value for 1 c.c. of the potassium cyanide solution.

The following are the reactions that occur:

Silver nitrate reacts with potassium iodide as follows:

$$Ag\ N\ O_3 + K\ I = Ag\ I + K\ N\ O_3$$

The reaction of nickel sulphate with potassium cyanide is as follows:

$$Ni\ S\ O_4 + 4K\ C\ N = (K\ C\ N)_2\ Ni\ (C\ N)_2) + K_2S\ O_4.$$

The silver iodide is dissolved by the potassium cyanide during titration forming the double salt potassium silver cyanide as in the following equation:

$$Ag\ I + 2K\ C\ N = K\ C\ N\ Ag\ C\ N + K\ I.$$

If cobalt is present it will be estimated with the nickel. Its presence is shown by the solution darkening.

SILVER PLATING SOLUTION.

Standard Formula:

Silver Chloride ..... 4 Ounces (av.)
Potassium Cyanide ... 12 " (av.)
Water .....1 Gallon (U.S.)
Silver determination:

Measure out 25 c.c. of the solution with a 25 c.c. pipette into a 400 c.c. beaker, using a long rubber tube on pipette for aspirating the solution so as to prevent it being sucked into the mouth. Add 100 c.c. of water to the beaker and heat almost to the boiling point, then precipitate the silver as silver sulphide (Ag_2 S) with hydrogen sulphide gas (H_2 S). When complete precipitation has taken place, filter off the silver sulphide on an E. and A. filter paper 13 cm., washing the precipitate with hydrogen sulphide water several times. The paper and precipitate is removed from the funnel, and the silver sulphide washed from the paper into a 250 c.c. beaker with water. (The adhering pieces on the paper can be removed with Conc. nitric acid). The silver sulphide is dissolved in a small quantity of Conc. nitric acid, then the solution is boiled to expel the nitrous fumes, as their presence will interfere with the titration. After boiling off the nitrous fumes the solution is cooled and diluted to about 150 c.c. with water and titrated as follows:

Add 5 c.c. of a cold saturated solution of iron alum (ferric ammonium sulphate). If

the solution becomes turbid, nitric acid is added drop by drop until clear. Place the beaker on a white surface and add the standard $\frac{N}{10}$ potassium sulphocyanate solution from a 50 c.c. burette with constant stirring until a faint permanent reddish tinge of ferric sulphocyanate—Fe_2 (S C N)$_6$—is produced. The number of c.c. used is noted and the ounces of silver chloride per gallon calculated as follows:

Multiply the c.c. of $\frac{N}{10}$ potassium sulphocyanate used by the silver chloride value for 1 c.c. (for exactly $\frac{N}{10}$ it is .01433 grams), then divide by 25 (number of c.c. taken for analysis). This will give the grams of silver chloride in 1c.c. of the plating solution. To convert this to ounces (av.) per gallon (U. S.), multiply by 133.54.

The following example will illustrate it: Used 52.3 c.c. $\frac{N}{10}$ potassium sulphocyanate; multiply by .01433 will equal .74946, and divide by 25 will equal .02997 grams silver chloride in 1 c.c. of plating solution, then multiply by 133.54, and the result will be 4 ounces of silver chloride per gallon (U. S.)

Standard $\frac{N}{10}$ Potassium Sulphocyanate:

Dissolve 20 grams of potassium sulphocyanate in water and dilute to two liters. Standardize it by taking 0.4 grams granulated silver (999 fine) in a 250 c.c. dilute nitric acid (equal parts of conc. nitric acid and water). After the silver is dissolved, the solution is boiled to expel nitrous fumes. When entirely free from nitrous fumes (this is shown by no more yellow fumes coming off) the solution is cooled and diluted to 150 c.c. with water; then add 5 c.c. of indicator (iron alum) and titrate with the potassium sulphocyanate solution until the first permanent pink is produced. The number of c.c. used divided into 0.4 gram, will give the grams of silver in 1 c.c. of the solution, and this multiplied by 1.3287 will give the grams of silver chloride in 1 c.c. of the potassium sulphocyanate solution.

The following are the reactions that take place in titrating:

$$Ag\ N\ O_3 + K\ S\ C\ N = Ag\ S\ C\ N + K\ N\ O_3$$

An excess of potassium sulphocyanate then reacts with iron alum as follows:

$$2\ Fe\ N\ H_4\ (S\ O_4)_2 + 6\ K\ S\ C\ N = Fe_2\ (S\ C\ N)_6\ N\ H_4)_2\ S\ O_4 + 3\ K_2\ S\ O_4.$$

This method is accurate in the presence of copper (not exceeding 70% arsenic, antimony, cadmium, lead, bismuth, tin, zinc, iron and

manganese. Mercury if present will interfere, and therefore should be removed before titrating.

Uncombined Cyanide determination:

Take 10 c.c. of the plating solution into a 400 c.c. beaker; add about 100 c.c. water and 2 c.c. of Conc. ammonium hydrate and about 1 c.c. of 2% potassium iodide solution; then run in from a 50 c.c. burette $\frac{N}{10}$ silver nitrate until a permanent white precipitate of silver iodide is formed. This indicates the end point. The number of c.c. of silver nitrate used is noted and calculated as follows:

1 c.c. $\frac{N}{10}$ Ag N O_3=.005202 gms. C. N. The number of c.c. Ag N O_3 used times .005202= "x" grams C N in 10 c.c. of the plating solution. Then "x" grams C N divided by 10 will give the grams of C N in 1 c.c. of plating solution, which multiplied by 133.54 will be the ounces (av.) of C N per gallon (U. S.).

This determination is figured as C N, not as K C N, as the majority of the potassium cyanides on the market contain large quantities of Na C N which would be included when figuring the uncombined cyanide as K C N.

The uncombined cyanide is the K C N or Na C N that has not combined with the Ag Cl to form the double salt Ag C N K C N as in the equation:

$Ag\ Cl + 2K\ C\ N = Ag\ C\ N\ K\ C\ N + K\ Cl.$

In titrating the free K C N or Na C N with Ag N O_3 the double salt (Ag C N K C N) is not titrated by the Ag N O_3, only the free K C N or Na C N as in the following equations:

$Ag\ N\ O_3 + 2\ K\ C\ N = Ag\ C\ N\ K\ C\ N + K\ N\ O_3$

Then an excess of Ag N O_3 reacts with the Kl as follows:

$Ag\ N\ O_3 + K\ I = Ag\ I + K\ N\ O_3$

Standard $\frac{N}{10}$ Silver Nitrate Solution:

Dissolve 33.978 grams of pure silver nitrate in water and dilute to two liters. To standardize take 0.25 grams C. P. sodium chloride (Merck's Reagent) in a 400 c.c. beaker; add 100 c.c. water, and when all of the salt has been dissolved add 1 c.c. of a 2% solution of neutral potassium chromate as an indicator.

Place beaker on a white surface and titrate with the silver solution from a burette until a faint red tinge is obtained. The end point is somewhat difficult to distinguish. The faint red tinge can be more distinctly seen if another beaker containing 150 c.c. water and 1 c.c. of the chromate solution is compared with it. The sodium chloride solution should be neutral or faintly alkaline and cold. The number of c.c. of silver nitrate solution used (exactly $\frac{N}{10}$ would take 42.76 c.c.) divided into

0.25 grams sodium chloride will give the number of grams of sodium chloride in 1 c.c. of the silver nitrate solution. The other values can be found by multiplying the sodium chloride value by the following factors:

Na Cl × 0.8898 = CN
" " 2.2275 = KCN
" " 1.6767 = NaCN

1 c.c. Exactly $\frac{N}{10}$ $AgNO_3$ = .005202 gms. CN

1 c.c. " $\frac{N}{10}$ $AgNO_3$ = .01302 " KCN

1 c.c. " $\frac{N}{10}$ $AgNO_3$ = .009802 " NaCN

1 c.c. " $\frac{N}{10}$ $AgNO_3$ = .005846 " NaCl

CYANIDE DETERMINATION IN POTASSIUM CYANIDE.

Weigh off about 15 grams of the potassium cyanide in a tared weighing bottle, dissolve in water without heat and dilute to 500 c.c.

Take out 10 c.c. with pipette into a beaker, add 2 c.c. of Conc. $N H_4 O H$ and 1 c.c. K I solution (2%) and about 100 c.c. water, then run in $\frac{N}{10}$ Ag $N O_3$ from a burette until a permanent white precipitate of silver iodide is formed. The number of c.c. of Ag $N O_3$ used

multiplied by .005202 and divided by the weight taken, then multiplied by 100 = % CN in sample.

Example:

15.281 grams of potassium cyanide were dissolved and diluted to 500 c.c., then 10 c.c. (.3051 grams) required 23.45 c.c. $\frac{N}{10}$ Ag N O_3

23.45 × .005202=.121988÷.3051=.3999×100 =39.99% C N.

Factors:

CN × 1.8843 = NaCN
CN × 2.5033 = KCN
NaCN × 0.53071 = CN
KCN × 0.39947 = CN
Ag × 1.3287 = AgCl
Ag × 0.4822 = CN
AgCl × 0.36291 = CN
Ag × 0.90847 = KCN
Ag × 0.68382 = NaCN

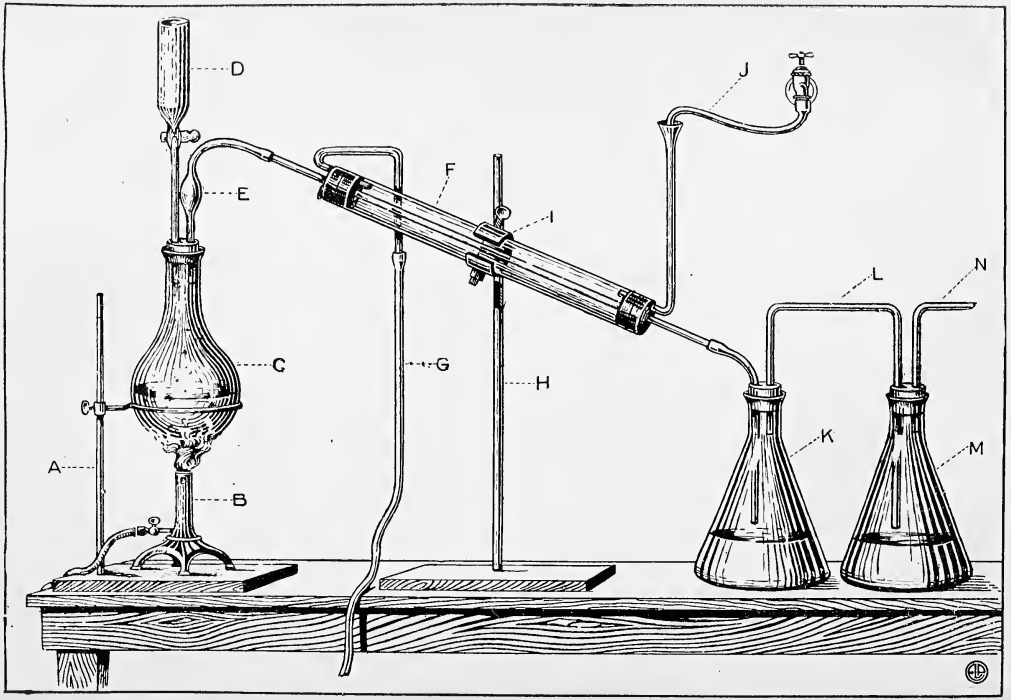


Fig. 18—The Apparatus Required for Determinations of Alkalies in Silver Solutions

TOTAL POTASSIUM AND SODIUM CYANIDE DETERMINATION IN SILVER SOLUTION.

In an apparatus as shown below distill 10 c.c. of silver solution to be tested for cyanide, potassium cyanide, or sodium cyanide, as follows:

Take 10 c.c. of silver solution, add 10 c.c. of water (H_2O), and place in Jena Kjeldahl Flask (C) connected with stop cock funnel (D) and connect with glass tube into Liebig Condenser (F). On receiving end of condenser have bottles (K & M) connected to collect steam. Place in funnel (D) 25 c.c. sulphuric acid ($H_2 S O_4$) and 25 c.c. water ($H_2 O$) and then place in bottle (K) at receiving end of condenser 50 c.c. water ($H_2 O$) and 1 gram of sodium hydrate (Na O H). Add the sulphuric acid and water that is in funnel (D) to the silver solution in Kjeldahl Flask (C) drop by drop while over flame (B). A slow stream of water must be kept running through the condenser (F) by connecting the lower rubber tube (J) with a water cock (O). When the solution is boiled in the Kjeldahl Flask (C) by means of a Bunsen burner flame (B) placed under flask, the steam passes into the inner

tube of the condenser (F). As this is surrounded by cold water the steam condenses and the distilled cyanide solution collects in the receiver (K) at the other end of condenser. When all the cyanide has come over, you will notice acid fumes in the flask. Then titrate the cyanide solution which has been collected in the receiver with $\frac{N}{10}$ silver nitrate solution ($Ag\ N\ O_3$).

Before titrating, take cyanide solution collected from condenser, and add 1 c.c. potassium iodide solution (K I) 2% solution, and about 100 c.c. water, then run in from a burette $\frac{N}{10}$ silver nitrate until a permanent white precipitate of silver iodide is formed. This indicates the end point. The number of c.c. of silver nitrate used is noted and calculated as follows:

1 c.c. $\frac{N}{10}$ $Ag\ N\ O_3$=.005202 gms. C N. The number of c.c. $Ag\ N\ O_3$ used times .005202= "x" grams C N in 10 c.c. of the plating solution. Then "x" grams C N divided by 10 will give the grams of C N in 1 c.c. of plating solu-

tion, which multiplied by 3785 will be the grams cyanide per gallon. As there are 30 grams in one ounce, divide by 30 which will be ounces per gallon. As there is only about 39 to 40% cyanide in potassium cyanide, you multiply the amount of cyanide by 2.5, which will give you the amount of potassium cyanide per gallon in silver solution, minus 20% which is lost.

The 20% loss in the above method is due to the cyanide decomposing, etc., and about 7% of it turns into carbonate of potassium.

POTASSIUM CARBONATE IN SILVER SOLUTION.

In an apparatus as shown in cut distill 5 c.c. of silver solution to be tested for potassium carbonate as follows:

Take 5 c.c. of silver solution, add 5 c.c. water, and place in Jena Kjeldahl flask connected with stop cock funnel, and connect with glass tube into Liebig Condenser. On receiving end of condenser have bottle connected to collect steam. Place in funnel 25 c.c. sulphuric acid ($H_2 S O_4$) and 25 c.c. water ($H_2 O$) and then place in bottle at receiving end of condenser 50 c.c. saturated solution of barium hydroxide and water. This is water that has taken into solution all the barium hydroxide that it will hold.

Add the sulphuric acid and water that is in funnel to silver solution drop by drop while over flame. A slow stream of water must be kept running through the condenser by connecting the lower rubber tube with a water cock. When the solution is boiled in the Kjeldahl flask by means of a bunsen burner flame placed under flask, the steam passes into the inner tube of the condenser. As this is surrounded by cold water the steam condenses and the potassium carbonate in the solution is broken up and carbon dioxide ($C\ O_2$) is distilled over the carbon dioxide combines with the barium hydroxide to form barium carbonate and water after the following equation:

$C\ O_2 + Ba\ (O\ H)_2 = Ba\ C\ O_3 + H_2\ O.$

The barium carbonate is a white precipitate.

When all is distilled over acid fumes will be seen in the flask, and the flame is taken away.

The barium carbonate is filtered off and heated in a weighed crucible.

When heated the barium carbonate is changed to barium oxide and is then weighed as such.

$Ba\ C\ O_3 = Ba\ O + C\ O_2.$

The barium oxide is figured to potassium carbonate in oz. per gal. as follows:

Wt. Ba O multiplied by .9 = Wt. $K_2\ C\ O_3$.

Wt. $K_2\ C\ O_3 \div$ No. of c.c. taken. Then multiplied by 133.54 = no. ozs. of $K_2\ C\ O_3$ in 1 gallon of silver solution.

APPARATUS AND CHEMICALS NECESSARY FOR THE METHODS OF ANALYSIS OF THE SOLUTIONS.

½	pound	...Potassium Iodide, C.P. cryst. U. S.P.
½	pound	...Potassium Sulphocyanate, C.P.
1	ounce	...Phenolphtaleine, Pure,
½	pound	...Acid Carbolic, C.P.
2	ounces	..Silver Nitrate, C.P.
1	pound	...Sodium Hydroxide Electrolytic sticks.
1	ounce	...Nickel Metal Co. free Gran. C.P.
25	grams	...Copper Electrolytic Foil Kb. Reag.
½	pound	...Aluminum Metal Foil 5/1000 in., pure.
1	pound	...Hydrogen Peroxide Marchand,
½	pound	...Ammonium Molybdate C.P.
5	pounds	..Iron Sulphide Broken Plates
1	book	....100 Strips each Litmus Blue
1	book	....100 Strips each Litmus Red
4	pounds	..Ammonium Hydrate 26 deg. Baker's anal. chem.
9	pounds	..Acid Sulphuric, 1
6	pounds	..Acid Hydrochloric
7	pounds	..Acid Nitric
1		.....Bunsen Burner,
4	feet	.....Rubber Tubing, Black, 3/16 inch diam., (4 ozs.)
3	feet	.....Rubber Tubing, ¼ inch diam., (6 ozs.)

1 .....Tripod, Iron,
3 .....Beakers, Jena, Griffin's, 250 c.c.,
2 ..... ditto 400 c.c.,
2 ..... ditto 600 c.c.
2 .....Flasks, Jena Erlenmeyer 500 c.c.
1 .....Cylinder, Lipped, Graduated 100 c.c.
2 .....Burettes, Mohr's, 50 c.c. $^1/_{10}$ c.c. subdivisions,
1 ..... ditto 100 c.c. $^1/_{10}$ c.c. subdivisions,
1 .....Support for Burettes,
1 .....Flask, 250 c.c.
1 ..... " 1000 c.c.

Reagent Bottles White Labels and Black Letters:—

1 .....Reagent Bottle 12 oz. "Acid Sulphuric Conc."
1 .....Reagent Bottle 12 oz. "Acid Sulphuric Dil."
1 .....Reagent Bottle 12 oz. "Acid Hydrochloric."
1 .....Reagent Bottle 12 oz. "Acid Nitric."
1 .....Reagent Bottle 12 oz. "Ammonium Hydrate."
2 .....Funnels, Glass, 3 inch diameter,
1 .....Nest of three Funnels, Glass
6 .....Funnels Cylindrical, 2 ozs.,
1 .....Pipette 5 c.c.
1 ..... " 10 c.c.
1 ..... " 25 c.c.

1 .....Pipette 50 c.c.
1 ..... " 100 c.c.
1 .....Thermometer 400 deg. F.,
1 box .....Labels, #201,
1 box ..... " 223,
1 .....Spatula, Blade 3 inches,
1 .....Gas Generator, Dudley's for H_2S
1 pound ...Glass Tubing, ¼ inch external diameter,
1 pound ...Glass stirring rods, assorted sizes,
1 .....File, Triangular, 4 inch,
1 .....Wash Bottle, 1 Pint,
1 .....Wash Bottle, 1 Quart,
1 .....Support for Funnels,
2 pkgs. ...Filter Papers, E. & A. diameter 13 cm.,
3 .....Watch Glasses 3¼ inch diameter,
3 ..... " " 4 inch diameter,
½ dozen ...Test Tubes 6 x ⅝ inch.,
1 .....Support for 13 Test Tubes,
1 .....Kjeldahl Connecting Bulbs Tube, small,
1 .....Condenser, Liebig end drawn out 15 inches,
2 .....Drying Tubes (Peligot Tubes) 6 inch.,
3 .....Rubber Stoppers, solid, No. 1, ... 6 ozs.
3 .....Rubber Stoppers, solid, No. 5, ... 6 ozs.
3 .....Rubber Stoppers, solid, No. 6, ... 6 ozs.

ANTIDOTES FOR POISONS USED IN PLATING ROOM.

Nitric, hydrochloric or sulphuric acids: Administer abundance of tepid water to act as an emetic, or swallow milk, the white of eggs, some lime, or a mixture of chalk and water.

If those acids in a concentrated state have been spilled on the hands or any part of the skin, apply a mixture of whiting and olive oil. If the quantity is very small, simple swilling with plenty of cold water will suffice.

Useful Mixture:

Mixture, is in cases of burning with strong sulphuric acid, is formed with 1 ounce of quick lime slacked with ¼ of an ounce of water, then adding to a quart of water. After standing 2 hours, pour off the clear liquid and mix it with olive oil to form thin paste.

Potassium Cyanide, Hydrocyanide Acid, etc.

If cyanides, such as a drop of an ordinary plating solution, has been accidentally swallowed, water as cold as possible should be run on the head and spine of the sufferer, and a dilute solution of iron acetate, citrate, or tartrate administered.

If hydrocyanic acid vapors have been inhaled, cold water should be applied as above, and the patient be caused to inhale atmospheric air containing a little of chlorine gas.

It is a dangerous practice to dip the arms into a plating solution to recover any work that has fallen off the wires, because the skin often absorbs cyanide liquids, causing painful sores, in such a case, wash well with water and apply with olive oil and lime water.

Mixture, Alkalies:

These bodies are the opposite to acids in character, so that acids may be used as antidotes. It is preferable to employ weak acids, such as vinegar or lemonade; but if these are not at hand, then use exceedingly dilute sulphuric or even nitric acid diluted, so that it just possesses a decidedly sour taste. After about 10 minutes take a few teaspoonsful of olive oil.

Mercury Salts.

The white of an egg is the best antidote in this case.

Sulphur or sulphureted hydrogen are also serviceable for the purpose.

Copper Salts.

The stomach should be quickly emptied by means of emetic, or in want of this, the patient should thrust his finger to the back of his throat so as to tickle the uvala, and thus induce vomiting. After vomiting, drink milk, white of an egg, or gum water.

Lead Salts:

Proceed as in case of copper salts. Lemonade, soda water and sodium carbonate are also serviceable.

Acid Vapors:

Admit immediately an abundance of fresh air, and inhale the vapors of ammonia, or a few drops of ammonia may be put into a glass of water and the solution drank. Take plenty of hot drinks, and excite warmth by friction. Employ hot foot-baths to remove the flood from the lungs. Keep the throat moist by sipping milk.

Removal of Stains, etc.

To remove stains of copper sulphate, or salts of mercury, gold, silver, etc., from the hands, wash them with a very dilute solution of ammonia, and with plenty of water; if the stains are old ones, they should be rubbed with the strongest acetic acid, and then treated as above.

GREASE, OIL, TAR, ETC., may be removed from the hands or clothes by rubbing with a rag saturated with benzine, turpentine, or carbon bisulphide.

CONTENTS.

ILLUSTRATIONS.

Page
Apparatus for Salt Water Gold Plating.....39
Apparatus Necessary for Determination of Cyanides....88
Conductors 2
Motor Generator "Excel-All" 20
"None-Such" Carboy Rocker .....26 and 36
"None-Such" Plating Barrel 25
"None-Such" Plating Barrel, Table Type 29
Plan of Plating Room 16
Plating Dyanamo, "Excel-All", ...17
Plating Rheostat 24
Rheostat and Wattmeter 41
Sprayers for Lacquering 46
Standard Ammeter 18
Standard Voltmeter 21
Steel Ball Burnishing Barrel, Double.....44
Steel Ball Burnishing Barrel, Single 43

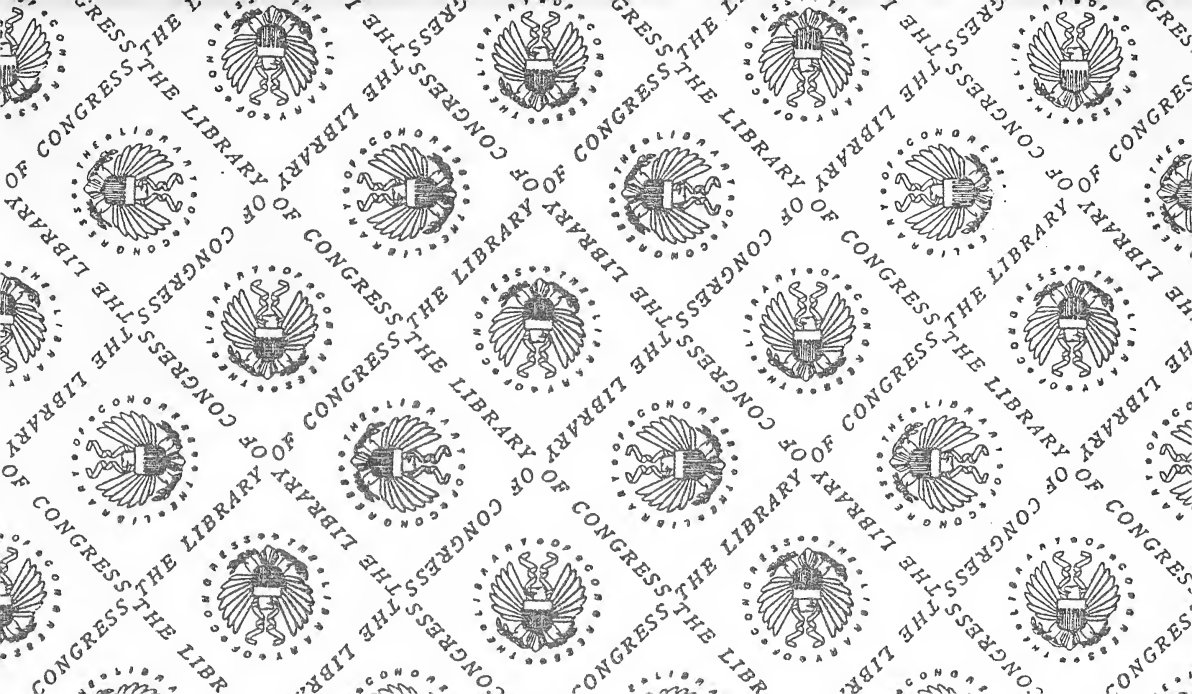
ARTICLES.

Acid Copper Plating Solution 47-59
Acid Dip for Matt Finish on Brass 52
Acid, Soldering 51
Air Brushes, Uses of.....46
Apparatus and Chemicals Necessary for Analyzing, List of 93
Arsenic, to Dissolve 49
Barbadienne Bronze, Formula for 53
Barrel Plating 25
Blue Oxidize on Any Metal 51
Brass, Black Dip on 57
Brass Plating Solution, Chemical Determinations in 66
Brass Plating, Solution for 22-66
Brass Solution 48
Brass, Steel Color on 47
Bronze Solution 56
Bronze Terra Cotta.....55
Burnishing with Steel Balls 42
Calculations for Chemical Analysis of Solutions 61, 63, 65, 66, 67 and 73

Page
Casket Hardware, to Silver Plate 27
Cast Iron, to Clean and Cleaning Solution for 3
Chemicals Used in Plating Room, List of 45
Chloride of Silver, Flux for Clearing 53
Conductors, Various Kinds 2
Copper or Brass, to Color Dark Brown 36
Copper, Dark Brown, Drab 48
Copper, Cyanide, Solution 48
Copper, Fine Brown Bronze on 53
Copper, Jet Black on 55
Copper Plating, Solution for 21
Copper, Red, Solution 48
Copper, Royal Formula for ..... 48 and 56
Copper, to Determine in Acid Copper Solution 59
Crystallized Tin Finish 54
Cyanide Copper Plating Solution, Analysis of 71
Equations, Some Simple Plating 8
Etching Paint for a Stop Off 58
Electrical Terms, Definitions of 1
Elements, a List of the 6
Formula for Color Making Paints and Inks 59
French Grey, Black Nickel Smut for 57
Galvanizing Solution 49
Gilding Solution for Table Ware 34
Gilders Wax 35
Gold, Assay Test of Any Gold Solution 74
Gold Dip Solution 52
Gold, Green, Solution for 37-51
Gold Plating, 14 to 18 Karat Color Directions for 35
Gold, Precipitate of 49
Gold Strip, Formula for 51
Gold, to Recover, From an Old Solution 58
Gun Metal Finish 47
Holloware, to Silver Plate 31
Iron, Bright Pickle for 50
Lacquer, Points on 39
Lacquer, Water Dip, Use of 41
Lead and Spelter, to Silver Plate 32
Metals, to Clean Before Plating 4
Metric Equivalents, Various 13
Nickel, Black, Solution ..... 50 and 56
Nickel Determination 76
Nickel Plating Solution, Analysis of 76

Page
Nickel Plating, Solution for 19
Old Ivory Finish 26
Ormolu Gold Finish on Lead Work 37
Plating Room, Electrical Requirements Necessary for the 15
Poisons Used in Plating Rooms, Antidotes for 96
Potassium Cyanide, Standard, Solution 79
Potassium Cyanide, to Determine Cyanide in 86
Potassium, Hydro Sulphuret of 50
Quick Electrotype Formula 50
Results Obtained by Analysis of Brass Solution 70
Rose Gold, Directions for Finishing 33
Salt Water Gold Solution, Outfit for 39
Sectional Gold, Paint for 55
Silver Dip Solution 56
Silver, Flux for Melting 52
Silver Nitrate, Standard, Solution 79
Silver Plating Solution, Standard Formula for 81
Silver Solder 56
Silver Solution, Brightener for 37
Silver Solution, Potassium Carbonate in....91
Silver Solutions, Simple Method for Testing 54
Silver Solution, Total Potassium and Sodium Cyanide in 89
Silver, to Separate, from Copper 57
Silver, to Strip, from Steel 58
Silver White Finish, Solution for....26
Strip for Brass, Copper or German Silver....49
Stains, to Remove 98
Steel, Blue Color on 52
Steel Knives, to Silver Plate 30
Sterling Silver, to Remove Fire Stains from 58
Sulphuret of Copper, to Detect Iron in 55
Sulphuric Acid, Determination in Acid Copper Solution 63
Tin, to Crystallize 54
Tin Solution 49
Verde Antique Paint 57
Verde Green Solution 52
Weights and Measures, Tables of Various Kinds of.. 9
Zinc, Determination in Brass Plating Solution 67

237 90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